

	1 of 44	Technical Reference: Re-Entry Field Inspection of Milling Components					
DOCUMENT NUMBER	CLASSIFICATION	DOCUMENT LEVEL	REVISION	ISSUE DATE	PREPARED BY	APPROVAL	
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Re-Entry Field Inspection Criteria of Milling Components

QuickCut™

Shallow-Angle QuickCut™



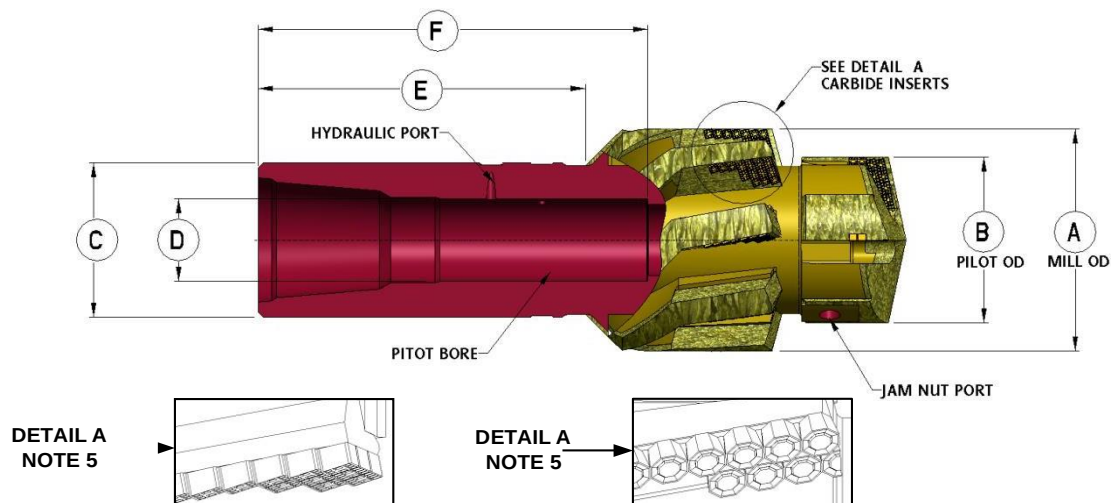
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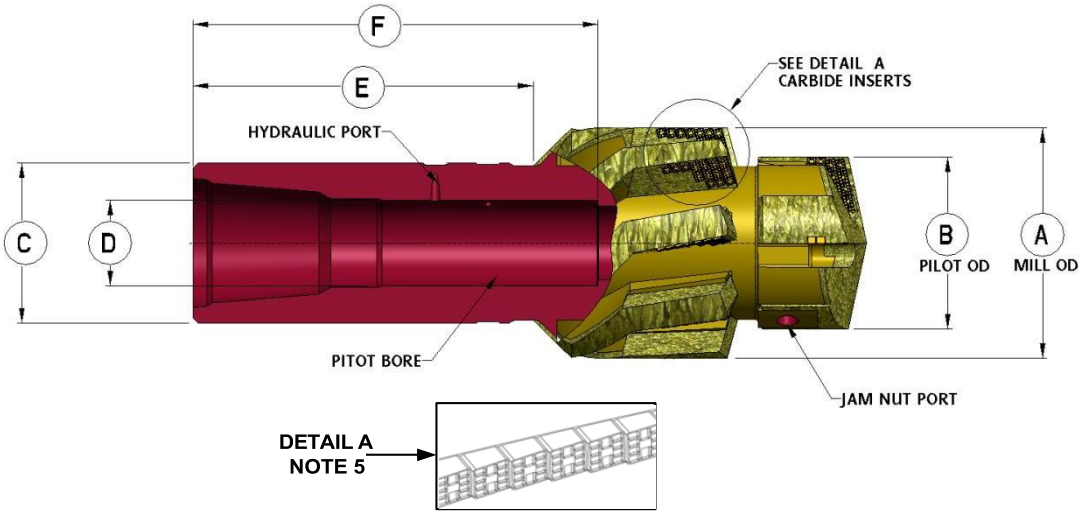


CASING DATA		Lead Mill PN:	Dimensional Parameters								
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F in.	Mill OD Type	Pilot OD Type
4 1/2	9.5	805523	Nominal	3.880	3.000	3.13	Check pitot bore with pitot sleeve. Ensure free passing & report if notice excessive play (Bore Dia NOM: 1.312; MIN: 1.312; MAX: 1.315)	10.50	11.32	Rough	Smooth
	10.5		MIN	3.880	2.985	3.10		10.00	10.82		
	11.6		MAX	3.910	3.000	3.16		10.50	11.35		
	13.5	805522	Nominal	3.750	3.000	3.13		10.50	11.32	Rough	Smooth
			MIN	3.750	2.985	3.10		10.00	10.82		
			MAX	3.780	3.000	3.16		10.50	11.35		
	15.1	1825168	Nominal	3.700	3.000	3.13		10.50	11.32	Rough	Smooth
			MIN	3.700	2.985	3.10		10.00	10.82		
			MAX	3.730	3.000	3.16		10.50	11.35		
	17	1818048	Nominal	3.615	3.000	3.13		10.50	11.32	Rough	Smooth
			MIN	3.615	2.985	3.10		10.00	10.82		
			MAX	3.645	3.000	3.16		10.50	11.35		
5	18	1128853	Nominal	4.125	3.000	3.13		10.50	11.32	Rough	Smooth
			MIN	4.125	2.985	3.10		10.00	10.82		
			MAX	4.155	3.000	3.16		10.50	11.35		
	23.2	805523	Nominal	3.880	3.000	3.13		10.50	11.32	Rough	Smooth
			MIN	3.880	2.985	3.10		10.00	10.82		
			MAX	3.910	3.000	3.16		10.50	11.35		

Carbide Application Acceptance Criteria

1. The crushed carbide grains shall be protruding and not merged in the weld media
2. The Mill OD shall be rough and inspector shall feel the sharp edges by hand
3. Insert faces and edges shall be clear and clean of brass (not covered)
4. All Inserts shall be free from damaged or broken edges
5. Carbide Inserts on Mill OD, Pilot OD are octagonal chip breaker & chip breaker negative rake face and this type applicable only for PN: 1825168 & 1818048. Rest all PN's are with Octagonal inserts.
6. The Pitot bore and hydraulic port shall be free of any washout
7. The jam nut thread shall be free of damage and debris. The inspector shall verify the Jam nut thread profile by assembly a new jam nut

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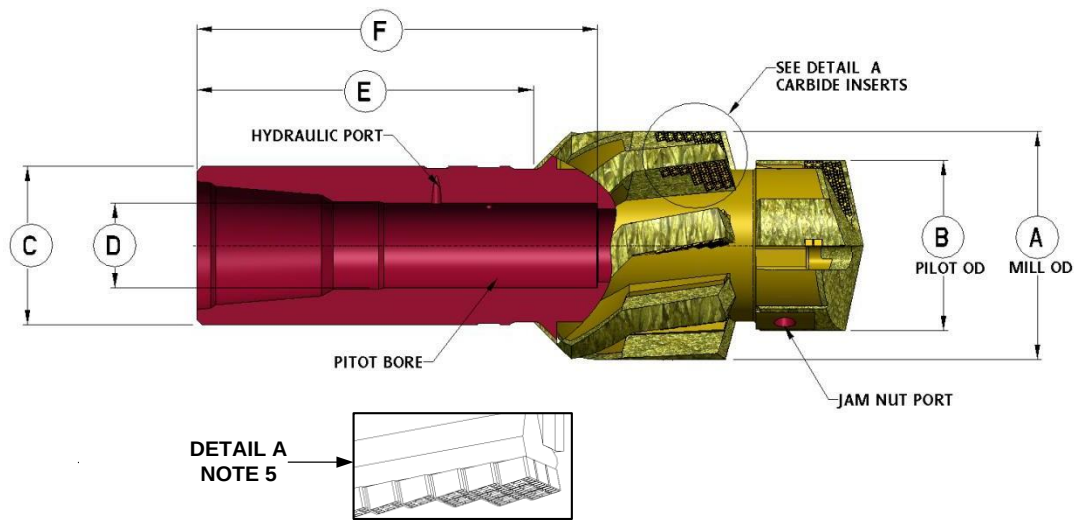


CASING DATA		Lead Mill PN:	Dimensional Parameters								
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F in.	Mill OD Type	Pilot OD Type
5 1/2	14	805528	Nominal	4.875	3.750	3.75	Check pitot bore with pitot sleeve. Ensure free passing & report if notice excessive play (Bore Dia NOM: 1.312; MIN: 1.312; MAX: 1.319)	10.25	11.50	Rough	Smooth
			MIN	4.875	3.735	3.72		9.75	11.00		
			MAX	4.905	3.750	3.78		10.25	11.53		
	15.5	805527	Nominal	4.750	3.750	3.75		10.25	11.50	Rough	Smooth
			MIN	4.750	3.735	3.72		9.75	11.00		
			MAX	4.780	3.750	3.78		10.25	11.53		
	17	805532	Nominal	4.625	3.375	3.13		10.25	11.50	Rough	Smooth
			MIN	4.625	3.360	3.10		9.75	11.00		
			MAX	4.655	3.375	3.16		10.25	11.53		
	20	805531	Nominal	4.500	3.375	3.13		10.25	11.50	Rough	Smooth
			MIN	4.500	3.360	3.10		9.75	11.00		
			MAX	4.530	3.375	3.16		10.25	11.53		
	23	805531	Nominal	4.420	3.375	3.13		10.25	11.50	Rough	Smooth
			MIN	4.420	3.360	3.10		9.75	11.00		
			MAX	4.450	3.375	3.16		10.25	11.53		
5 3/4	17.6	2477890	Nominal	4.420	3.375	3.13		10.25	11.50	Rough	Smooth
			MIN	4.420	3.360	3.10		9.75	11.00		
			MAX	4.450	3.375	3.16		10.25	11.53		
5 3/4	17.6	805528	Nominal	4.875	3.750	3.75		10.25	11.50	Rough	Smooth
			MIN	4.875	3.735	3.72		9.75	11.00		
			MAX	4.905	3.750	3.78		10.25	11.53		

Carbide Application Acceptance Criteria

1. The crushed carbide grains shall be protruding and not merged in the weld media
2. The Mill OD shall be rough and inspector shall feel the sharp edges by hand
3. Insert faces and edges shall be clear and clean of brass (not covered)
4. All Inserts shall be free from damaged or broken edges
5. Carbide Inserts on Mill OD, Pilot OD are chip breaker negative rake face
6. The Pitot bore and hydraulic port shall be free of any washout
7. The jam nut thread shall be free of damage and debris. The inspector shall verify the Jam nut thread profile by assembly a new jam nut

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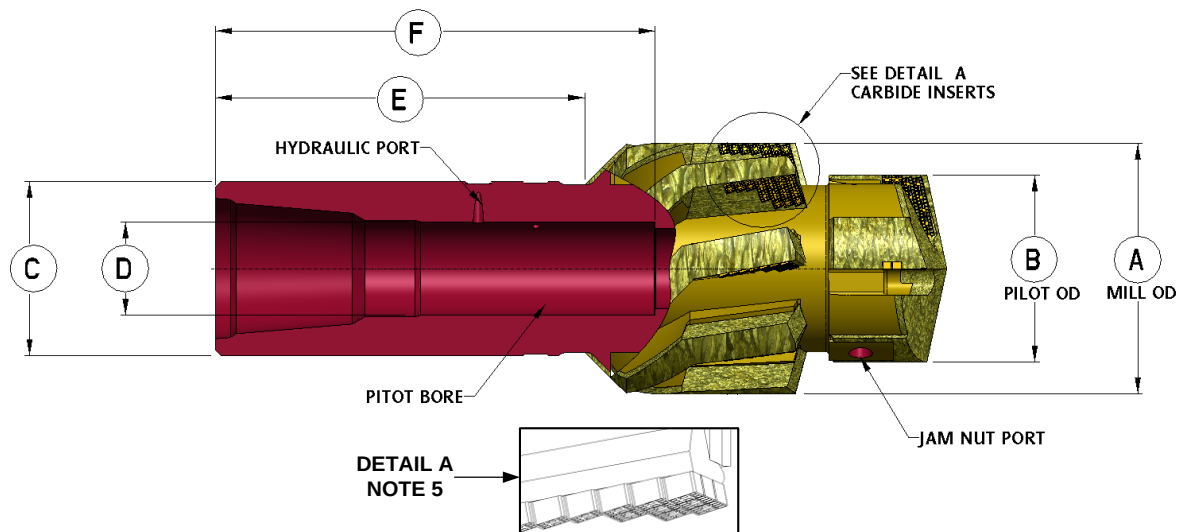


CASING DATA		Lead Mill PN:	Dimensional Parameters								
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F in.	Mill OD Type	Pilot OD Type
6 5/8	17	2074229	Nominal	6.000	4.625	4.25	Check pitot bore with pitot sleeve. Ensure free passing & report if notice excessive play (Bore Dia NOM: 2.750; MIN: 2.750; MAX: 2.755)	13.32	15.44	Rough	Smooth
			MIN	6.000	4.610	4.22		12.72	14.94		
			MAX	6.015	4.625	4.28		13.32	15.47		
	20	2074226	Nominal	5.875	4.625	4.25		13.32	15.44	Rough	Smooth
			MIN	5.875	4.610	4.22		12.72	14.94		
			MAX	5.890	4.625	4.28		13.32	15.47		
	24	895728	Nominal	5.750	3.875	4.25		13.00	15.44	Rough	Smooth
			MIN	5.750	3.860	4.22		12.50	14.94		
			MAX	5.765	3.875	4.28		13.00	15.47		
	28	884653	Nominal	5.625	3.875	4.25		13.00	15.44	Rough	Smooth
			MIN	5.625	3.860	4.22		12.50	14.94		
			MAX	5.640	3.875	4.28		13.00	15.47		
	32	881726	Nominal	5.500	3.875	4.25		13.00	15.44	Rough	Smooth
			MIN	5.500	3.860	4.22		12.50	14.94		
			MAX	5.515	3.875	4.28		13.00	15.47		
	34	1909549	Nominal	5.470	3.875	4.25		13.00	15.44	Rough	Smooth
			MIN	5.470	3.860	4.22		12.50	14.94		
			MAX	5.485	3.875	4.28		13.00	15.47		

Carbide Application Acceptance Criteria

1. The crushed carbide grains shall be protruding and not merged in the weld media
2. The Mill OD shall be rough and inspector shall feel the sharp edges by hand
3. Insert faces and edges shall be clear and clean of brass (not covered)
4. All Inserts shall be free from damaged or broken edges
5. Carbide Inserts on Mill OD, Pilot OD are chip breaker negative rake face
6. The Pitot bore and hydraulic port shall be free of any washout
7. The jam nut thread shall be free of damage and debris. The inspector shall verify the Jam nut thread profile by assembly a new jam nut

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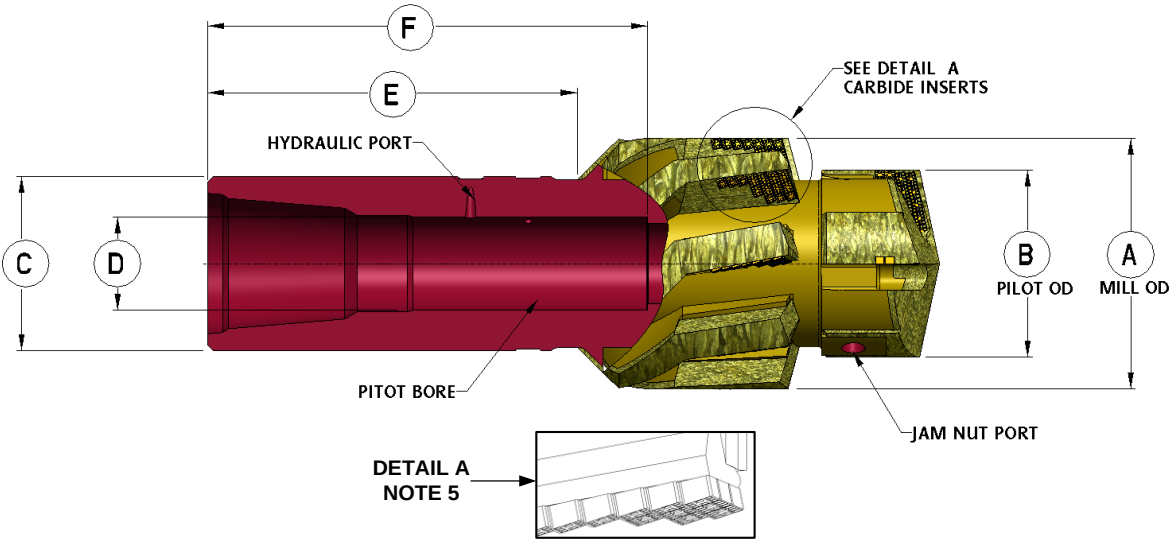


CASING DATA		Lead Mill PN:	Dimensional Parameters								
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F in.	Mill OD Type	Pilot OD Type
7	20	2073112	Nominal	6.250	5.000	4.25	(Bore Dia NOM: 2.750; MIN: 2.750; MAX: 2.755) Check pitot bore with pitot sleeve. Ensure free passing & report if notice excessive play	13.22	15.44	Rough	Smooth
	23.0 SD		MIN	6.250	4.985	4.22		12.72	14.94		
			MAX	6.265	5.000	4.28		13.22	15.47		
	23	2073116	Nominal	6.125	5.000	4.25		13.22	15.44	Rough	Smooth
	26		MIN	6.125	4.985	4.22		12.72	14.94		
	29.0 SD		MAX	6.140	5.000	4.28		13.22	15.47		
	29	2074229	Nominal	6.000	4.625	4.25		13.32	15.44	Rough	Smooth
			MIN	6.000	4.610	4.22		12.72	14.94		
			MAX	6.015	4.625	4.28		13.32	15.47		
	32	2074226	Nominal	5.875	4.625	4.25		13.32	15.44	Rough	Smooth
			MIN	5.875	4.610	4.22		12.72	14.94		
			MAX	5.890	4.625	4.28		13.32	15.47		
	32.0 SD	2074229	Nominal	6.000	4.625	4.25		13.32	15.44	Rough	Smooth
			MIN	6.000	4.610	4.22		12.72	14.94		
			MAX	6.015	4.625	4.28		13.32	15.47		
	35	2074226	Nominal	5.875	4.625	4.25		13.32	15.44	Rough	Smooth
			MIN	5.875	4.610	4.22		12.72	14.94		
			MAX	5.890	4.625	4.28		13.32	15.47		
	38	2420578	Nominal	5.750	4.500	4.25		13.32	15.44	Rough	Smooth
			MIN	5.750	4.500	4.22		12.72	14.94		
			MAX	5.765	4.485	4.28		13.32	15.47		

Carbide Application Acceptance Criteria

1. The crushed carbide grains shall be protruding and not merged in the weld media
2. The Mill OD shall be rough and inspector shall feel the sharp edges by hand
3. Insert faces and edges shall be clear and clean of brass (not covered)
4. All Inserts shall be free from damaged or broken edges
5. Carbide Inserts on Mill OD, Pilot OD are chip breaker negative rake face
6. The Pitot bore and hydraulic port shall be free of any washout
7. The jam nut thread shall be free of damage and debris. The inspector shall verify the Jam nut thread profile by assembly a new jam nut

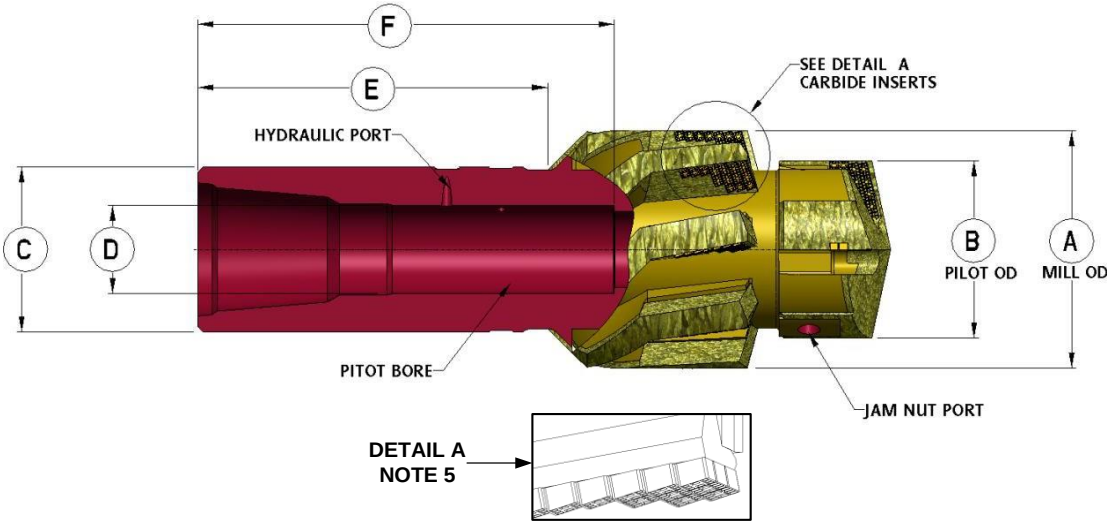
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CASING DATA		Lead Mill PN:	Dimensional Parameters								
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F in.	Mill OD Type	Pilot OD Type
7 5/8	24	1851441	Nominal	6.875	5.375	4.25	Check pitot bore with pitot sleeve. Ensure free passing & report if notice excessive play (Bore Dia NOM: 2.750; MIN: 2.750; MAX: 2.755)	12.30	15.44	Rough	Smooth
			MIN	6.875	5.360	4.22		11.80	14.94		
			MAX	6.905	5.375	4.28		12.30	15.47		
	26.4	1851440	Nominal	6.750	5.375	4.25		12.30	15.44	Rough	Smooth
			MIN	6.750	5.360	4.22		11.80	14.94		
			MAX	6.780	5.375	4.28		12.30	15.47		
	29.7	1851439	Nominal	6.625	5.125	4.25		12.30	15.44	Rough	Smooth
			MIN	6.625	5.110	4.22		11.80	14.94		
			MAX	6.655	5.125	4.28		12.30	15.47		
	33.7	1851439	Nominal	6.625	5.125	4.25		12.30	15.44	Rough	Smooth
			MIN	6.625	5.110	4.22		11.80	14.94		
			MAX	6.655	5.125	4.28		12.30	15.47		
	39	1824836	Nominal	6.500	5.125	4.25		12.30	15.44	Rough	Smooth
			MIN	6.500	5.110	4.22		11.80	14.94		
			MAX	6.530	5.125	4.28		12.30	15.47		

Carbide Application Acceptance Criteria

1. The crushed carbide grains shall be protruding and not merged in the weld media
2. The Mill OD shall be rough and inspector shall feel the sharp edges by hand
3. Insert faces and edges shall be clear and clean of brass (not covered)
4. All Inserts shall be free from damaged or broken edges
5. Carbide Inserts on Mill OD, Pilot OD are chip breaker, negative rake face.
6. The Pitot bore and hydraulic port shall be free of any washout
7. The jam nut thread shall be free of damage and debris. The inspector shall verify the Jam nut thread profile by assembly a new jam nut

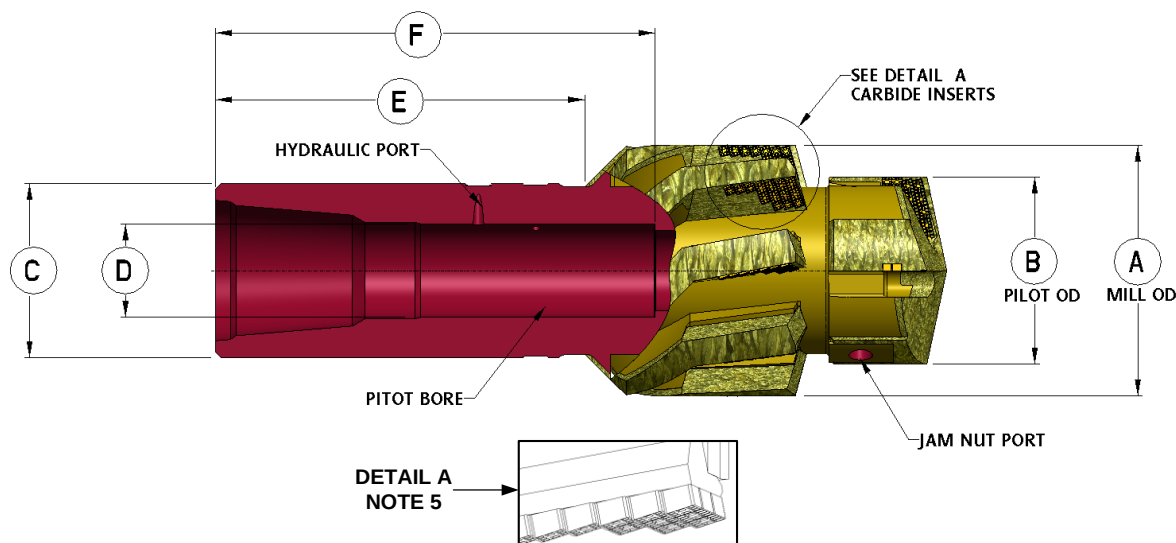


CASING DATA		Lead Mill PN:	Dimensional Parameters								
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F in.	Mill OD Type	Pilot OD Type
8 5/8	23-28	1948005	Nominal	7.875	6.125	5.63	Check pitot bore with pitot sleeve. Ensure free passing & report if notice excessive play (Bore Dia NOM: 2.750; MIN: 2.750; MAX: 2.755)	13.50	14.81	Rough	Smooth
			MIN	7.875	6.110	5.62		13.00	14.31		
			MAX	7.890	6.125	5.64		13.50	14.96		
	29.4-32.4	1966539	Nominal	7.750	6.125	5.63		13.50	14.81	Rough	Smooth
			MIN	7.750	6.110	5.62		13.00	14.31		
			MAX	7.765	6.125	5.64		13.50	14.96		
	36-38	1966540	Nominal	7.625	6.125	5.63		13.50	14.81	Rough	Smooth
			MIN	7.625	6.110	5.62		13.00	14.31		
			MAX	7.640	6.125	5.64		13.50	14.96		

Carbide Application Acceptance Criteria

1. The crushed carbide grains shall be protruding and not merged in the weld media
2. The Mill OD shall be rough and inspector shall feel the sharp edges by hand
3. Insert faces and edges shall be clear and clean of brass (not covered)
4. All Inserts shall be free from damaged or broken edges
5. Carbide Inserts on Mill OD, Pilot OD are chip breaker, negative rake face.
6. The Pitot bore and hydraulic port shall be free of any washout
7. The jam nut thread shall be free of damage and debris. The inspector shall verify the Jam nut thread profile by assembly a new jam nut

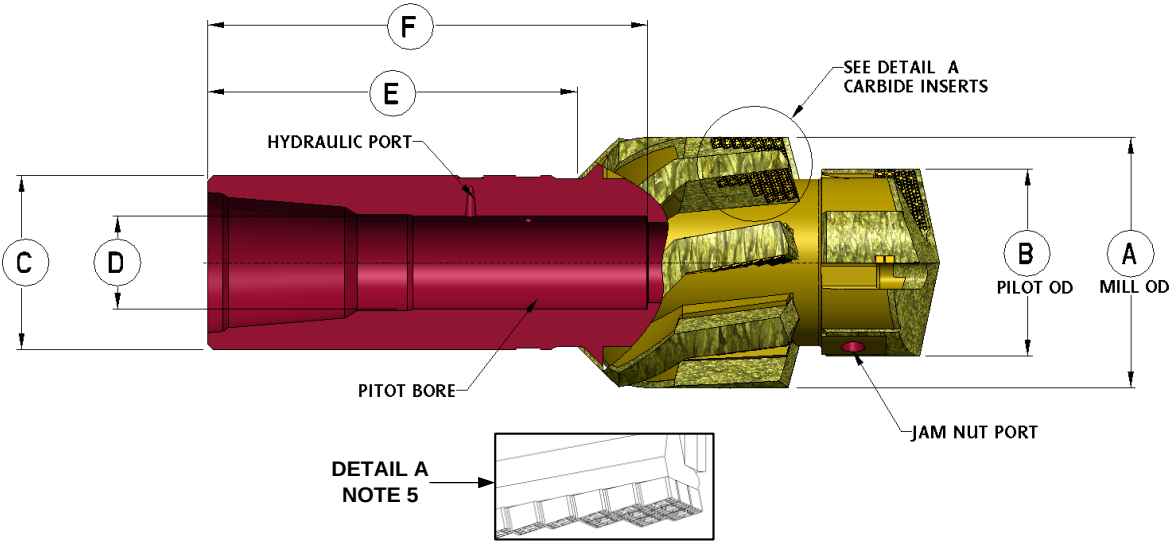
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CASING DATA		Lead Mill PN:	Dimensional Parameters								
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F in.	Mill OD Type	Pilot OD Type
9 5/8	32.3	1851438	Nominal	8.875	7.000	5.75	(Bore Dia NOM: 2.750; MIN: 2.750; MAX: 2.755) Check pitot bore with pitot sleeve. Ensure free passing & report if notice excessive play	12.00	14.81	Rough	Smooth
			MIN	8.875	6.985	5.72		11.50	14.31		
			MAX	8.890	7.000	5.78		12.00	14.84		
	36	1851437	Nominal	8.750	7.000	5.75		12.00	14.81	Rough	Smooth
			MIN	8.750	6.985	5.72		11.50	14.31		
			MAX	8.765	7.000	5.78		12.00	14.84		
	40	1851436	Nominal	8.625	7.000	5.75		12.00	14.81	Rough	Smooth
	43.5 SD		MIN	8.625	6.985	5.72		11.50	14.31		
			MAX	8.640	7.000	5.78		12.00	14.84		
	43.5	1744636	Nominal	8.500	6.375	5.75		13.63	14.81	Rough	Smooth
	47		MIN	8.500	6.375	5.72		13.13	14.31		
	53.5 SD		MAX	8.515	6.360	5.78		13.63	14.84		
	53.5	1818043	Nominal	8.375	6.375	5.75		13.63	14.81	Rough	Smooth
			MIN	8.375	6.375	5.72		13.13	14.31		
			MAX	8.390	6.360	5.78		13.63	14.84		
	58.4 STD	1818042	Nominal	8.250	6.375	5.75		13.63	14.81	Rough	Smooth
			MIN	8.250	6.375	5.72		13.13	14.31		
			MAX	8.265	6.360	5.78		13.63	14.84		

Carbide Application Acceptance Criteria

1. The crushed carbide grains shall be protruding and not merged in the weld media
2. The Mill OD shall be rough and inspector shall feel the sharp edges by hand
3. Insert faces and edges shall be clear and clean of brass (not covered)
4. All Inserts shall be free from damaged or broken edges
5. Carbide Inserts on Mill OD, Pilot OD are chip breaker, negative rake face.
6. The Pitot bore and hydraulic port shall be free of any washout
7. The jam nut thread shall be free of damage and debris. The inspector shall verify the Jam nut thread profile by assembly a new jam nut

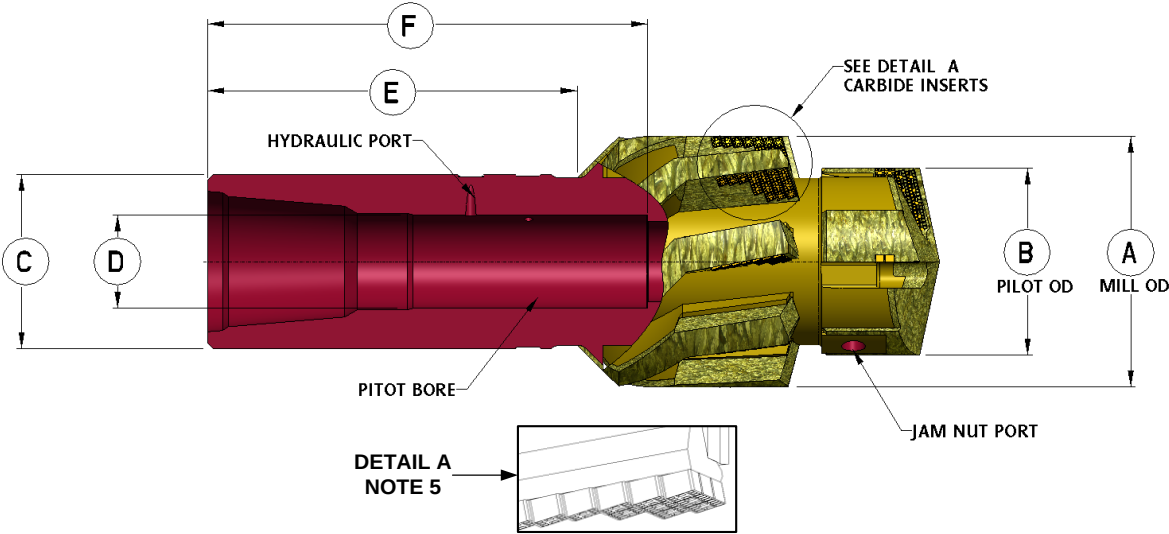


CASING DATA		Lead Mill PN:	Dimensional Parameters								
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F in.	Mill OD Type	Pilot OD Type
10 3/4	32.75	1899472	Nominal	9.875	7.000	6.50	Check pitot bore with pitot sleeve. Ensure free passing & report if notice excessive play (Bore Dia NOM: 3.500; MIN: 3.500; MAX: 3.505)	13.75	16.44	Rough	Smooth
			MIN	9.875	6.985	6.47		13.25	15.94		
			MAX	9.890	7.000	6.53		13.75	16.47		
	40.5 to 45.5	1899471	Nominal	9.750	7.000	6.50		13.75	16.44	Rough	Smooth
			MIN	9.750	6.985	6.47		13.25	15.94		
			MAX	9.765	7.000	6.53		13.75	16.47		
	51	1899470	Nominal	9.625	7.000	6.50		13.75	16.44	Rough	Smooth
			MIN	9.625	6.985	6.47		13.25	15.94		
			MAX	9.640	7.000	6.53		13.75	16.47		
	55.5	1899469	Nominal	9.500	7.000	6.50		13.75	16.44	Rough	Smooth
			MIN	9.500	6.985	6.47		13.25	15.94		
			MAX	9.515	7.000	6.53		13.75	16.47		
	60-65	1899468	Nominal	9.375	7.000	6.50		13.75	16.44	Rough	Smooth
			MIN	9.375	6.985	6.47		13.25	15.94		
			MAX	9.390	7.000	6.53		13.75	16.47		

Carbide Application Acceptance Criteria

1. The crushed carbide grains shall be protruding and not merged in the weld media
2. The Mill OD shall be rough and inspector shall feel the sharp edges by hand
3. Insert faces and edges shall be clear and clean of brass (not covered)
4. All Inserts shall be free from damaged or broken edges
5. Carbide Inserts on Mill OD, Pilot OD are chip breaker, negative rake face.
6. The Pitot bore and hydraulic port shall be free of any washout
7. The jam nut thread shall be free of damage and debris. The inspector shall verify the Jam nut thread profile by assembly a new jam nut

	11 of 44	QC, SAQC Lead Mill Field Inspection Criteria				
DOCUMENT NUMBER	CLASSIFICATION	DOCUMENT LEVEL	REVISION	ISSUE DATE	PREPARED BY	APPROVAL
GL-INTS-OEPS-L4-459	CONTROLLED	Technical Manual	L	OCT 2024	Santosh Bhadran	Ron Barker

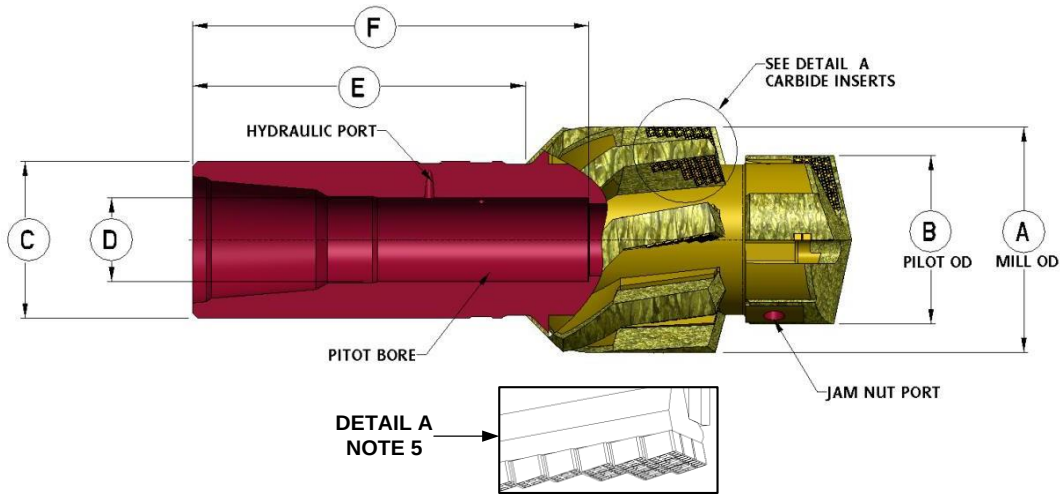


CASING DATA		Lead Mill PN:	Dimensional Parameters								
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F in.	Mill OD Type	Pilot OD Type
11 3/4	38	1817900	Nominal	10.875	8.125	7.50	Check pitot bore with pitot sleeve. Ensure free passing & report if notice excessive play (Bore Dia NOM: 3.500; MIN: 3.500; MAX: 3.505)	14.50	16.94	Rough	Smooth
			MIN	10.875	8.110	7.47		14.00	16.44		
			MAX	10.890	8.125	7.53		14.50	16.97		
	42	1817899	Nominal	10.750	8.125	7.50		14.50	16.94	Rough	Smooth
			MIN	10.750	8.110	7.47		14.00	16.44		
			MAX	10.765	8.125	7.53		14.50	16.97		
	47	1817899	Nominal	10.750	8.125	7.50		14.50	16.94	Rough	Smooth
			MIN	10.750	8.110	7.47		14.00	16.44		
			MAX	10.765	8.125	7.53		14.50	16.97		
	54	1817898	Nominal	10.625	8.125	7.50		14.50	16.94	Rough	Smooth
			MIN	10.625	8.110	7.47		14.00	16.44		
			MAX	10.640	8.125	7.53		14.50	16.97		
	60	1817897	Nominal	10.500	8.125	7.50		14.50	16.94	Rough	Smooth
			MIN	10.500	8.110	7.47		14.00	16.44		
			MAX	10.515	8.125	7.53		14.50	16.97		

Carbide Application Acceptance Criteria

1. The crushed carbide grains shall be protruding and not merged in the weld media
2. The Mill OD shall be rough and inspector shall feel the sharp edges by hand
3. Insert faces and edges shall be clear and clean of brass (not covered)
4. All Inserts shall be free from damaged or broken edges
5. Carbide Inserts on Mill OD, Pilot OD are chip breaker, negative rake face.
6. The Pitot bore and hydraulic port shall be free of any washout
7. The jam nut thread shall be free of damage and debris. The inspector shall verify the Jam nut thread profile by assembly a new jam nut

	12 of 44	QC, SAQC Lead Mill Field Inspection Criteria				
DOCUMENT NUMBER	CLASSIFICATION	DOCUMENT LEVEL	REVISION	ISSUE DATE	PREPARED BY	APPROVAL
GL-INTS-OEPS-L4-459	CONTROLLED	Technical Manual	L	OCT 2024	Santosh Bhadran	Ron Barker

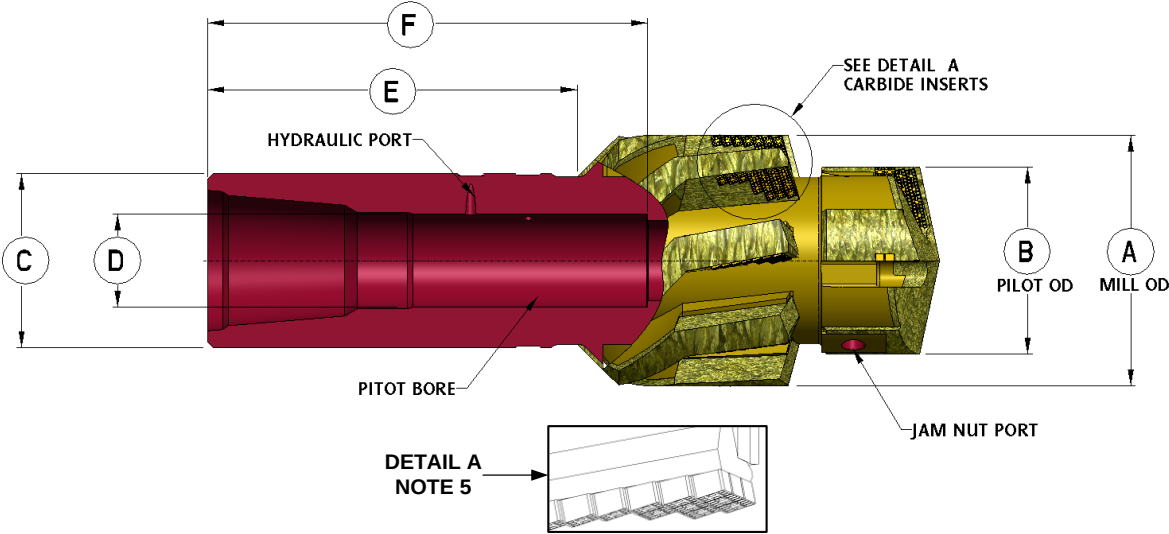


CASING DATA		Lead Mill PN:	Dimensional Parameters								
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F in.	Mill OD Type	Pilot OD Type
13 3/8	48-72	1797146	Nominal	12.250	10.000	7.50	Check pitot bore with pitot sleeve. Ensure free passing & report if notice excessive play (Bore Dia NOM: 3.500; MIN: 3.500; MAX: 3.505)	14.00	16.94	Rough	Smooth
			MIN	12.250	9.985	7.47		13.50	16.44		
			MAX	12.265	10.000	7.53		14.00	16.97		
	48-72 SPCL	2139609	Nominal	12.250	10.000	7.50		14.00	16.94	Rough	Smooth
			MIN	12.240	9.985	7.47		13.50	16.44		
			MAX	12.250	10.000	7.53		14.00	16.97		
	72	2620006	Nominal	12.125	10.000	7.50		14.00	16.94	Rough	Smooth
			MIN	12.125	9.985	7.47		13.50	16.44		
			MAX	12.155	10.000	7.53		14.00	16.97		

Carbide Application Acceptance Criteria

1. The crushed carbide grains shall be protruding and not merged in the weld media
2. The Mill OD shall be rough and inspector shall feel the sharp edges by hand
3. Insert faces and edges shall be clear and clean of brass (not covered)
4. All Inserts shall be free from damaged or broken edges
5. Carbide Inserts on Mill OD, Pilot OD are chip breaker, negative rake face.
6. The Pitot bore and hydraulic port shall be free of any washout
7. The jam nut thread shall be free of damage and debris. The inspector shall verify the Jam nut thread profile by assembly a new jam nut

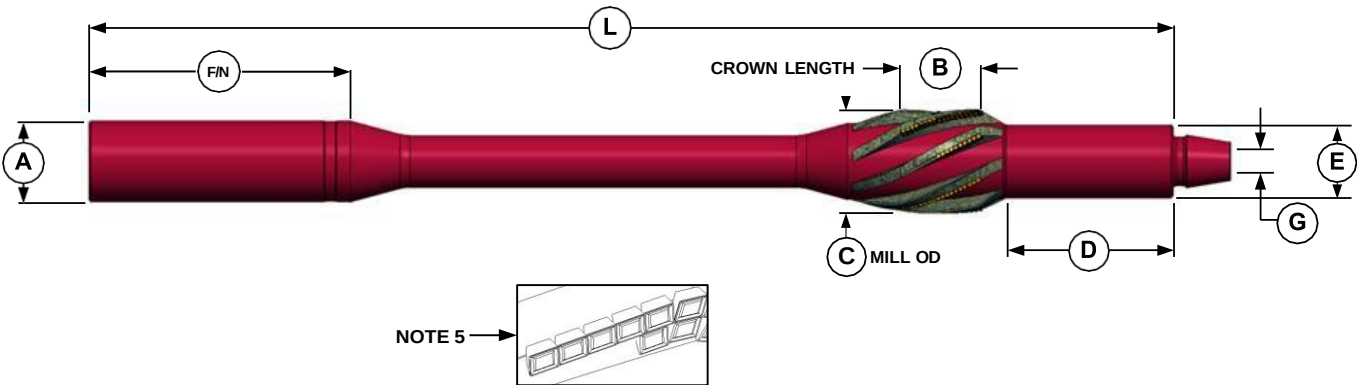
	13 of 44	QC, SAQC Lead Mill Field Inspection Criteria				
DOCUMENT NUMBER	CLASSIFICATION	DOCUMENT LEVEL	REVISION	ISSUE DATE	PREPARED BY	APPROVAL
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CASING DATA		Lead Mill PN:	Dimensional Parameters								
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F in.	Mill OD Type	Pilot OD Type
16	55-84	1177711	Nominal	14.750	12.250	9.00	Check pitot bore with pitot sleeve. Ensure free passing & report if notice excessive play (Bore Dia NOM: 5.000; MIN: 5.000; MAX: 5.005)	15.00	16.82	Rough	Smooth
			MIN	14.750	12.235	8.97		14.50	16.32		
			MAX	14.765	12.250	9.03		15.00	16.85		
	94.5-95	1179354	Nominal	14.500	12.250	9.00		15.00	16.82	Rough	Smooth
			MIN	14.500	12.235	8.97		14.50	16.32		
			MAX	14.515	12.250	9.03		15.00	16.85		
18 5/8	78-94.5	1203222	Nominal	17.500	14.250	9.00		19.40	22.82	Rough	Smooth
			MIN	17.500	14.235	8.97		18.90	22.32		
			MAX	17.515	14.265	9.03		19.40	22.85		
	98-138	1214176	Nominal	17.000	14.250	9.00		19.40	22.82	Rough	Smooth
			MIN	17.000	14.235	8.97		18.90	22.32		
			MAX	17.015	14.265	9.03		19.40	22.85		
20	90-187	1203222	Nominal	17.500	14.250	9.00		19.40	22.82	Rough	Smooth
			MIN	17.500	14.235	8.97		18.90	22.32		
			MAX	17.515	14.265	9.03		19.40	22.85		

Carbide Application Acceptance Criteria

1. The crushed carbide grains shall be protruding and not merged in the weld media
2. The Mill OD shall be rough and inspector shall feel the sharp edges by hand
3. Insert faces and edges shall be clear and clean of brass (not covered)
4. All Inserts shall be free from damaged or broken edges
5. Carbide Inserts on Mill OD, Pilot OD are chip breaker, negative rake face.
6. The Pitot bore and hydraulic port shall be free of any washout
7. The jam nut thread shall be free of damage and debris. The inspector shall verify the Jam nut thread profile by assembly a new jam nut

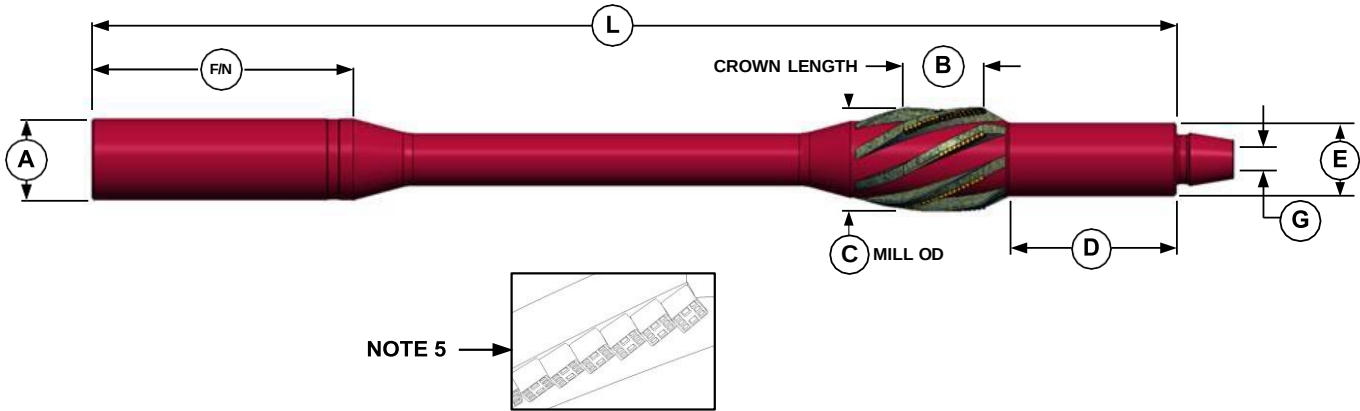


CASING DATA		Flex Mill PN:	Dimensional Parameters									
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F/N in.	G in.	L in.	Mill OD Type
4 1/2	9.5	279589	Nominal	3.13	6.00	3.875	6.84	3.13	15.90	1.00	50.90	Rough
	10.5		MIN	3.10	5.50	3.875	5.50	3.10	8.00	0.97	41.66	
	11.6		MAX	3.16	6.50	3.890	7.34	3.16	16.40	1.03	51.40	
	13.5	279588	Nominal	3.13	6.00	3.750	6.84	3.13	15.90	1.00	50.90	Rough
			MIN	3.10	5.50	3.750	5.50	3.10	8.00	0.97	41.66	
			MAX	3.16	6.50	3.765	7.34	3.16	16.40	1.03	51.40	
	15.1	826287	Nominal	3.13	6.00	3.700	6.84	3.13	15.90	1.00	50.90	Rough
			MIN	3.10	5.50	3.700	5.50	3.10	8.00	0.97	41.66	
			MAX	3.16	6.50	3.715	7.34	3.16	16.40	1.03	51.40	
	17	2634036	Nominal	3.13	6.00	3.615	6.84	3.13	15.90	1.00	50.90	Rough
			MIN	3.10	5.50	3.615	5.50	3.10	8.00	0.97	41.66	
			MAX	3.16	6.50	3.630	7.34	3.16	16.40	1.03	51.40	
5	18	1128874	Nominal	3.13	6.00	4.125	6.84	3.13	15.90	1.00	50.90	Rough
			MIN	3.10	5.50	4.125	5.50	3.10	8.00	0.97	41.66	
			MAX	3.16	6.50	4.140	7.34	3.16	16.40	1.03	51.40	
	23.2	279589	Nominal	3.13	6.00	3.875	6.84	3.13	15.90	1.00	50.90	Rough
			MIN	3.10	5.50	3.875	5.50	3.10	8.00	0.97	41.66	
			MAX	3.16	6.50	3.890	7.34	3.16	16.40	1.03	51.40	

Carbide Application Acceptance Criteria

1. The crushed carbide grains shall be protruding and not merged in the weld media
2. The Mill OD shall be rough and inspector shall feel the sharp edges by hand
3. Insert faces and edges shall be clear and clean of brass (not covered)
4. All Inserts shall be free from damaged or broken edges
5. Carbide Inserts on Mill OD are square chip breaker

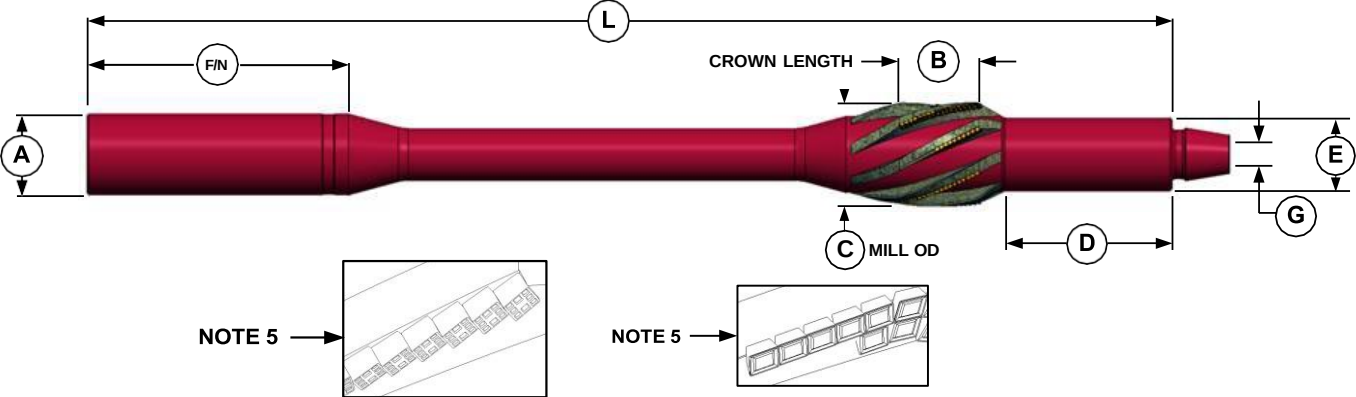
	15 of 44	QC Flex Mill Field Inspection Criteria				
DOCUMENT NUMBER	CLASSIFICATION	DOCUMENT LEVEL	REVISION	ISSUE DATE	PREPARED BY	APPROVAL
GL-INTS-OEPS-L4-459	CONTROLLED	Technical Manual	L	OCT 2024	Santosh Bhadran	Ron Barker



CASING DATA		Flex Mill PN:	Dimensional Parameters										Mill OD Type
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F/N in.	G in.	L in.		
5 1/2	14	281183	Nominal	3.88	6.10	4.875	11.25	3.75	16.00	1.25	54.50		Rough
			MIN	3.85	5.60	4.875	8.00	3.72	9.00	1.22	44.25		
			MAX	3.91	6.60	4.905	11.75	3.78	16.50	1.28	55.00		
	15.5	281180	Nominal	3.88	6.10	4.750	11.25	3.75	16.00	1.25	54.50		Rough
			MIN	3.85	5.60	4.750	8.00	3.72	9.00	1.22	44.25		
			MAX	3.91	6.60	4.780	11.75	3.78	16.50	1.28	55.00		
	17	281180	Nominal	3.88	6.10	4.750	11.25	3.75	16.00	1.25	54.50		Rough
			MIN	3.85	5.60	4.750	8.00	3.72	9.00	1.22	44.25		
			MAX	3.91	6.60	4.780	11.75	3.78	16.50	1.28	55.00		
	20	303434	Nominal	3.75	6.10	4.625	11.25	3.13	15.30	1.25	56.10		Rough
			MIN	3.72	5.60	4.625	7.00	3.10	9.00	1.22	45.55		
			MAX	3.78	6.60	4.655	11.75	3.16	15.80	1.28	56.60		
	23	303435	Nominal	3.75	6.10	4.500	11.25	3.13	15.30	1.25	56.10		Rough
			MIN	3.72	5.60	4.500	7.00	3.10	9.00	1.22	45.55		
			MAX	3.78	6.60	4.530	11.75	3.16	15.80	1.28	56.60		
5 3/4	17.6	2610825	Nominal	3.75	6.10	4.420	11.25	3.13	15.30	1.25	56.10		Rough
			MIN	3.72	5.60	4.420	7.00	3.10	9.00	1.22	45.55		
			MAX	3.78	6.60	4.450	11.75	3.16	15.80	1.28	56.60		
			Nominal	3.88	6.10	4.875	11.25	3.75	16.00	1.25	54.50		
			MIN	3.85	5.60	4.875	7.00	3.72	9.00	1.22	43.25		
			MAX	3.91	6.60	4.900	11.75	3.78	16.50	1.28	55.00		

Carbide Application Acceptance Criteria

1. The crushed carbide grains shall be protruding and not merged in the weld media
2. The Mill OD shall be rough and inspector shall feel the sharp edges by hand
3. Insert faces and edges shall be clear and clean of brass (not covered)
4. All Inserts shall be free from damaged or broken edges
5. Carbide Inserts on Mill OD are chip breaker negative rake face



CASING DATA		Flex Mill PN:	Dimensional Parameters									
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F/N in.	G in.	L in.	Mill OD Type
6 5/8	17	124593	Nominal	4.88	5.00	6.000	8.00	4.25	20.00	1.50	64.40	Rough
			MIN	4.85	4.50	6.000	7.00	4.22	10.50	1.47	53.90	
			MAX	4.91	5.50	6.015	8.50	4.28	20.50	1.53	64.90	
	20	126751	Nominal	4.88	5.00	5.875	8.00	4.25	20.00	1.50	64.40	Rough
			MIN	4.85	4.50	5.875	7.00	4.22	10.50	1.47	53.90	
			MAX	4.91	5.50	5.890	8.50	4.28	20.50	1.53	64.90	
	24	904820	Nominal	4.75	7.50	5.750	8.80	4.25	20.30	1.50	94.40	Rough
			MIN	4.72	7.00	5.750	7.00	4.22	10.50	1.47	82.80	
			MAX	4.78	8.00	5.765	9.30	4.28	20.80	1.53	94.90	
	28	904817	Nominal	4.75	7.50	5.625	8.80	4.25	20.30	1.50	94.40	Rough
			MIN	4.72	7.00	5.625	7.00	4.22	10.50	1.47	82.80	
			MAX	4.78	8.00	5.640	9.30	4.28	20.80	1.53	94.90	
	32	904677	Nominal	4.75	7.50	5.500	8.80	4.25	20.30	1.50	94.40	Rough
			MIN	4.72	7.00	5.500	7.00	4.22	10.50	1.47	82.80	
			MAX	4.78	8.00	5.515	9.30	4.28	20.80	1.53	94.90	
	34	1909553	Nominal	4.75	7.50	5.470	8.80	4.25	20.30	1.50	94.40	Rough
			MIN	4.72	7.00	5.470	7.00	4.22	10.50	1.47	82.80	
			MAX	4.78	8.00	5.485	9.30	4.28	20.80	1.53	94.90	

Carbide Application Acceptance Criteria

1.

The crushed carbide grains shall be protruding and not merged in the weld media
2.

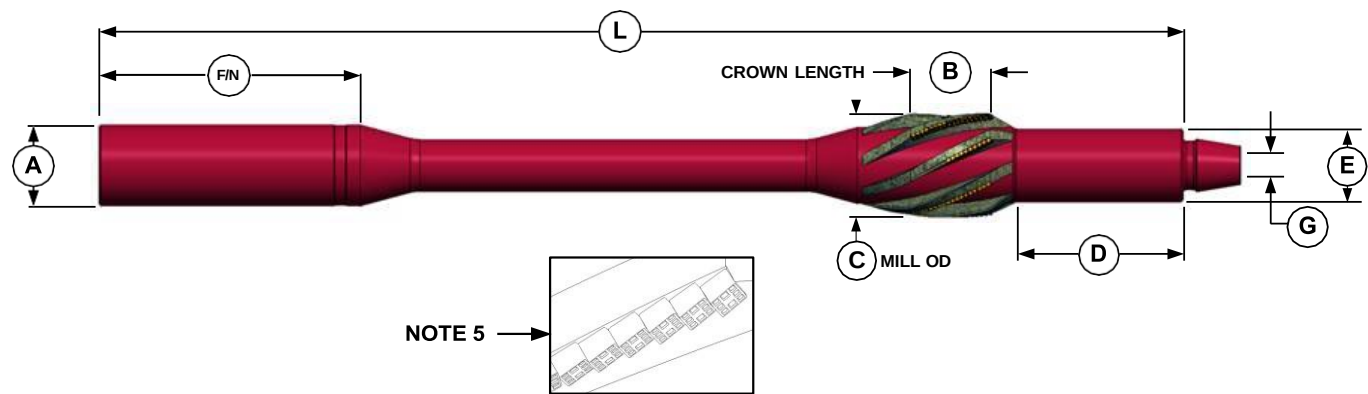
The Mill OD shall be rough and inspector shall feel the sharp edges by hand
3.

Insert faces and edges shall be clear and clean of brass (not covered)
4.

All Inserts shall be free from damaged or broken edges
5.

Carbide Inserts on Mill OD are square chip breaker & chip breaker negative rake face and this type applicable only for PN: 124593 & 126751.

	17 of 44	QC Flex Mill Field Inspection Criteria				
DOCUMENT NUMBER	CLASSIFICATION	DOCUMENT LEVEL	REVISION	ISSUE DATE	PREPARED BY	APPROVAL
GL-INTS-OEPS-L4-459	CONTROLLED	Technical Manual	L	OCT 2024	Santosh Bhadran	Ron Barker

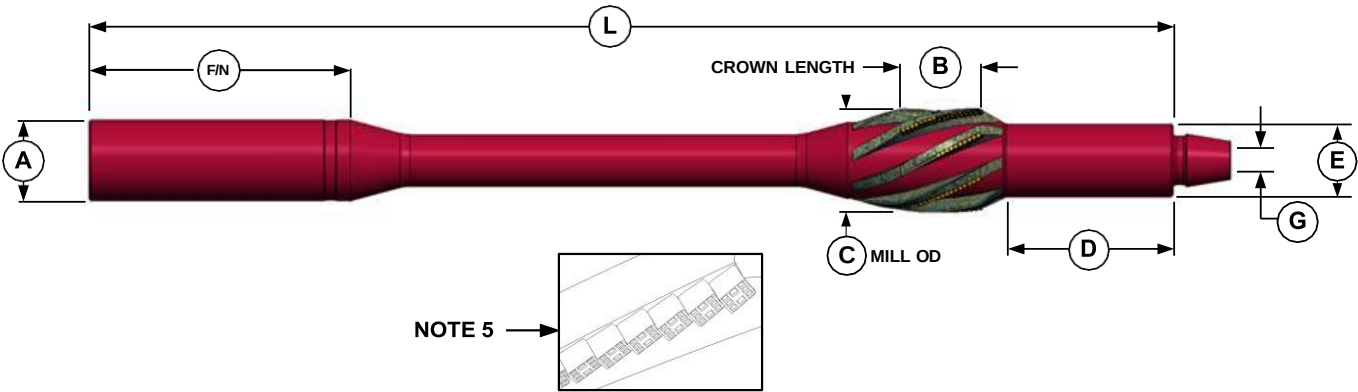


CASING DATA		Flex Mill PN:	Dimensional Parameters									
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F/N in.	G in.	L in.	Mill OD Type
7	20	126752	Nominal	4.88	5.00	6.250	8.00	4.25	20.00	1.50	64.40	Rough
	23.0 SD		MIN	4.85	4.50	6.250	7.00	4.22	10.50	1.47	53.90	
			MAX	4.91	5.50	6.265	8.50	4.28	20.50	1.53	64.90	
	23	123850	Nominal	4.88	5.00	6.125	8.00	4.25	20.00	1.50	64.40	Rough
	26		MIN	4.85	4.50	6.125	7.00	4.22	10.50	1.47	53.90	
	29.0 SD		MAX	4.91	5.50	6.140	8.50	4.28	20.50	1.53	64.90	
	29	124593	Nominal	4.88	5.00	6.000	8.00	4.25	20.00	1.50	64.40	Rough
			MIN	4.85	4.50	6.000	7.00	4.22	10.50	1.47	53.90	
			MAX	4.91	5.50	6.015	8.50	4.28	20.50	1.53	64.90	
	32	126751	Nominal	4.88	5.00	5.875	8.00	4.25	20.00	1.50	64.40	Rough
			MIN	4.85	4.50	5.875	7.00	4.22	10.50	1.47	53.90	
			MAX	4.91	5.50	5.890	8.50	4.28	20.50	1.53	64.90	
	32.0 SD	124593	Nominal	4.88	5.00	6.000	8.00	4.25	20.00	1.50	64.40	Rough
			MIN	4.85	4.50	6.000	7.00	4.22	10.50	1.47	53.90	
			MAX	4.91	5.50	6.015	8.50	4.28	20.50	1.53	64.90	
	35	126751	Nominal	4.88	5.00	5.875	8.00	4.25	20.00	1.50	64.40	Rough
			MIN	4.85	4.50	5.875	7.00	4.22	10.50	1.47	53.90	
			MAX	4.91	5.50	5.890	8.50	4.28	20.50	1.53	64.90	
	38	731469	Nominal	4.88	5.00	5.750	8.00	4.25	20.00	1.50	64.40	Rough
			MIN	4.85	4.50	5.750	7.00	4.22	10.50	1.47	53.90	
			MAX	4.91	5.50	5.765	8.50	4.28	20.50	1.53	64.90	

Carbide Application Acceptance Criteria

1. The crushed carbide grains shall be protruding and not merged in the weld media
2. The Mill OD shall be rough and inspector shall feel the sharp edges by hand
3. Insert faces and edges shall be clear and clean of brass (not covered)
4. All Inserts shall be free from damaged or broken edges
5. Carbide Inserts on Mill OD are chip breaker negative rake face

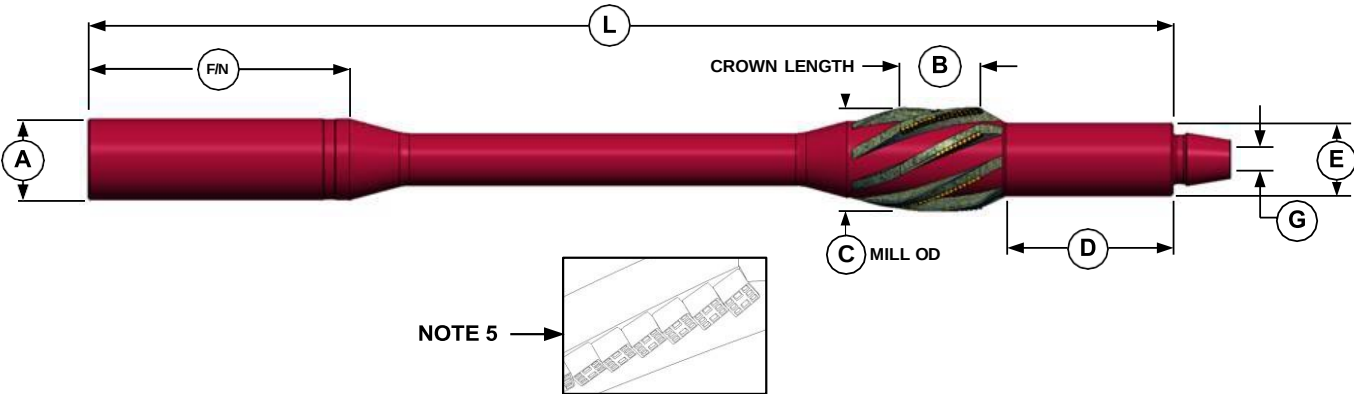
	18 of 44	QC Flex Mill Field Inspection Criteria				
DOCUMENT NUMBER	CLASSIFICATION	DOCUMENT LEVEL	REVISION	ISSUE DATE	PREPARED BY	APPROVAL
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CASING DATA		Flex Mill PN:	Dimensional Parameters									
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F/N in.	G in.	L in.	Mill OD Type
7 5/8	24	291786	Nominal	4.88	5.00	6.875	8.00	4.25	20.00	1.50	64.40	Rough
			MIN	4.85	4.50	6.875	7.00	4.22	10.50	1.47	53.90	
			MAX	4.91	5.50	6.905	8.50	4.28	20.50	1.53	63.90	
	26.4	291785	Nominal	4.88	5.00	6.750	8.00	4.25	20.00	1.50	64.40	Rough
	29.7		MIN	4.85	4.50	6.750	7.00	4.22	10.50	1.47	53.90	
			MAX	4.91	5.50	6.780	8.50	4.28	20.50	1.53	63.90	
	33.7	178642	Nominal	4.88	5.00	6.625	8.00	4.25	20.00	1.50	64.40	Rough
			MIN	4.85	4.50	6.625	7.00	4.22	10.50	1.47	53.90	
			MAX	4.91	5.50	6.655	8.50	4.28	20.50	1.53	63.90	
	39	178641	Nominal	4.88	5.00	6.500	8.00	4.25	20.00	1.50	64.40	Rough
			MIN	4.85	4.50	6.500	7.00	4.22	10.50	1.47	53.90	
			MAX	4.91	5.50	6.530	8.50	4.28	20.50	1.53	63.90	

Carbide Application Acceptance Criteria

1. The crushed carbide grains shall be protruding and not merged in the weld media
2. The Mill OD shall be rough and inspector shall feel the sharp edges by hand
3. Insert faces and edges shall be clear and clean of brass (not covered)
4. All Inserts shall be free from damaged or broken edges
5. Carbide Inserts on Mill OD are chip breaker negative rake face

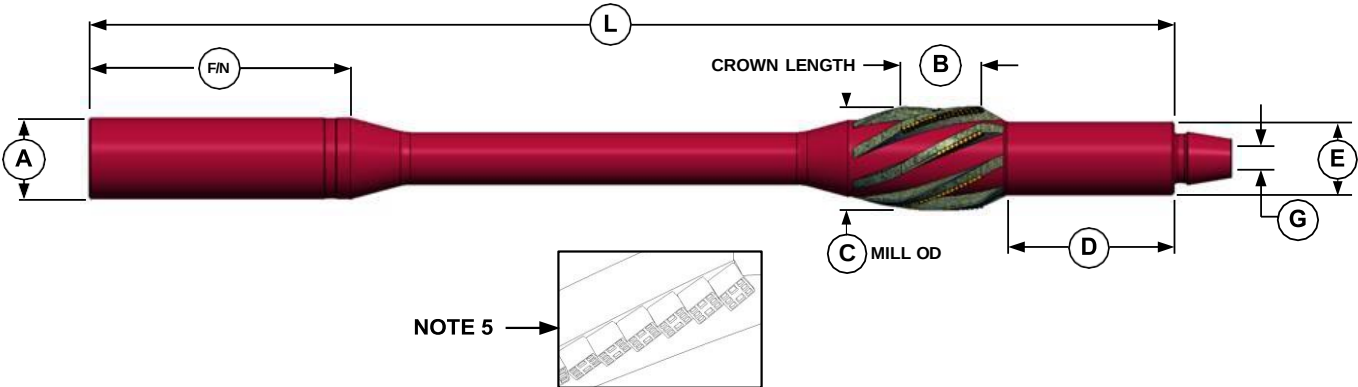


CASING DATA		Flex Mill PN:	Dimensional Parameters									
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F/N in.	G in.	L in.	Mill OD Type
8 5/8	23-28	1964299	Nominal	6.25	6.09	7.875	12.80	5.63	20.00	2.00	92.94	Rough
			MIN	6.22	5.59	7.875	10.00	5.60	12.00	1.97	82.14	
			MAX	6.28	6.59	7.905	13.30	5.66	20.50	2.03	93.44	
	29.4-32.4	1964300	Nominal	6.25	6.09	7.750	12.80	5.63	20.00	2.00	92.94	Rough
			MIN	6.22	5.59	7.750	10.00	5.60	12.00	1.97	82.14	
			MAX	6.28	6.59	7.780	13.30	5.66	20.50	2.03	93.44	
	36-38	1964301	Nominal	6.25	6.09	7.625	12.80	5.63	20.00	2.00	92.94	Rough
			MIN	6.22	5.59	7.625	10.00	5.60	12.00	1.97	82.14	
			MAX	6.28	6.59	7.655	13.30	5.66	20.50	2.03	93.44	

Carbide Application Acceptance Criteria

- 1. The crushed carbide grains shall be protruding and not merged in the weld media
- 2. The Mill OD shall be rough and inspector shall feel the sharp edges by hand
- 3. Insert faces and edges shall be clear and clean of brass (not covered)
- 4. All Inserts shall be free from damaged or broken edges
- 5. Carbide Inserts on Mill OD are chip breaker, negative rake face

	20 of 44	QC Flex Mill Field Inspection Criteria				
DOCUMENT NUMBER	CLASSIFICATION	DOCUMENT LEVEL	REVISION	ISSUE DATE	PREPARED BY	APPROVAL
GL-INTS-OEPS-L4-459	CONTROLLED	Technical Manual	L	OCT 2024	Santosh Bhadran	Ron Barker

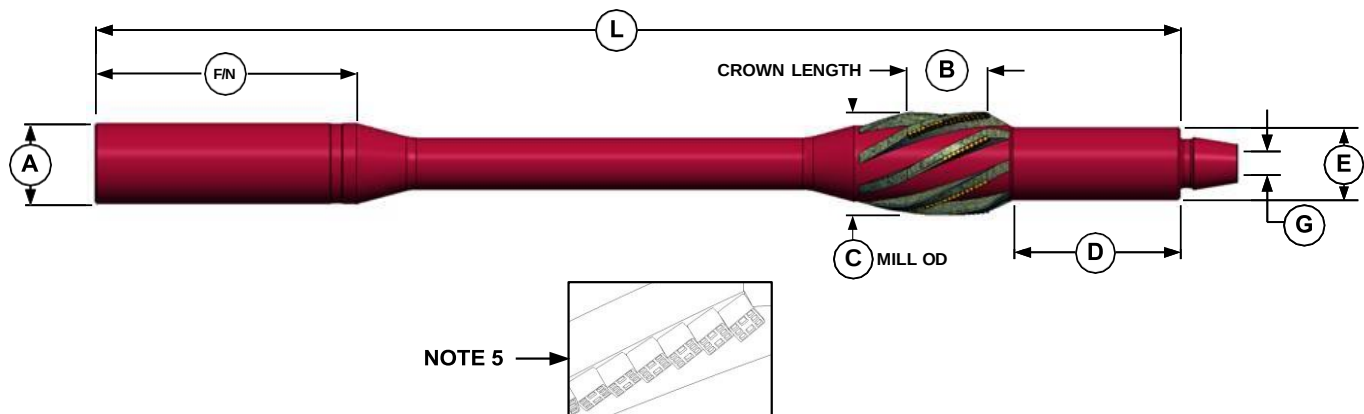


CASING DATA		Flex Mill PN:	Dimensional Parameters									
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F/N in.	G in.	L in.	Mill OD Type
9 5/8	32.3	125901	Nominal	6.38	5.00	8.875	12.30	5.75	20.00	2.25	101.80	Rough
			MIN	6.35	4.50	8.875	10.00	5.72	12.00	2.22	91.50	
			MAX	6.41	5.50	8.890	12.80	5.78	20.50	2.28	102.30	
	36	125902	Nominal	6.38	5.00	8.750	12.30	5.75	20.00	2.25	101.80	Rough
			MIN	6.35	4.50	8.750	10.00	5.72	12.00	2.22	91.50	
			MAX	6.41	5.50	8.765	12.80	5.78	20.50	2.28	102.30	
	40	125903	Nominal	6.38	5.00	8.625	12.30	5.75	20.00	2.25	101.80	Rough
	43.5 SD		MIN	6.35	4.50	8.625	10.00	5.72	12.00	2.22	91.50	
			MAX	6.41	5.50	8.640	12.80	5.78	20.50	2.28	102.30	
	43.5	115953	Nominal	6.38	5.00	8.500	12.30	5.75	20.00	2.25	101.80	Rough
	47		MIN	6.35	4.50	8.500	10.00	5.72	12.00	2.22	91.50	
	53.5 SD		MAX	6.41	5.50	8.515	12.80	5.78	20.50	2.28	102.30	
	53.5	289544	Nominal	6.38	5.00	8.375	12.30	5.75	20.00	2.25	101.80	Rough
			MIN	6.35	4.50	8.375	10.00	5.72	12.00	2.22	91.50	
			MAX	6.41	5.50	8.390	12.80	5.78	20.50	2.28	102.30	
	58.4 STD	1388470	Nominal	6.38	5.00	8.250	12.30	5.75	20.00	2.25	101.80	Rough
			MIN	6.35	4.50	8.250	10.00	5.72	12.00	2.22	91.50	
			MAX	6.41	5.50	8.265	12.80	5.78	20.50	2.28	102.30	

Carbide Application Acceptance Criteria

1. The crushed carbide grains shall be protruding and not merged in the weld media
2. The Mill OD shall be rough and inspector shall feel the sharp edges by hand
3. Insert faces and edges shall be clear and clean of brass (not covered)
4. All Inserts shall be free from damaged or broken edges
5. Carbide Inserts on Mill OD are chip breaker negative rake face

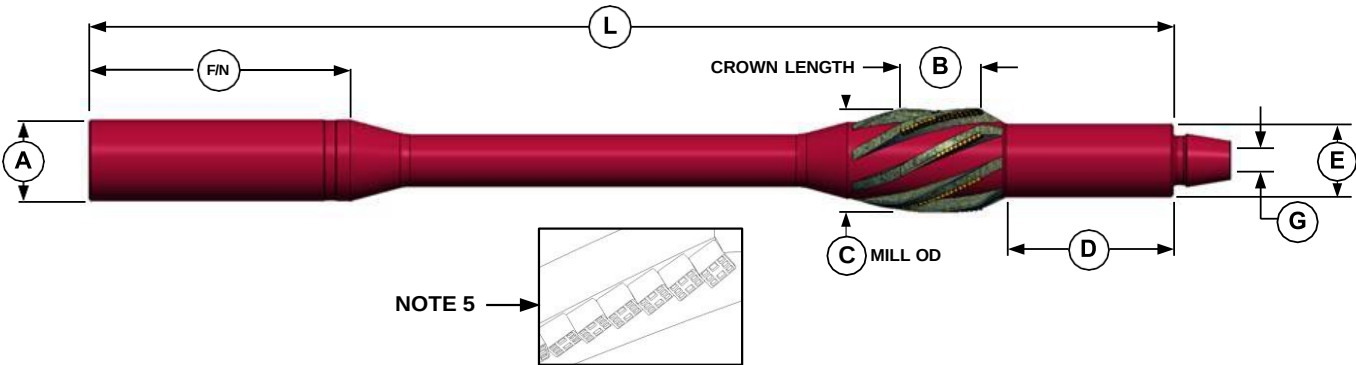
	21 of 44	QC Flex Mill Field Inspection Criteria				
DOCUMENT NUMBER	CLASSIFICATION	DOCUMENT LEVEL	REVISION	ISSUE DATE	PREPARED BY	APPROVAL
GL-INTS-OEPS-L4-459	CONTROLLED	Technical Manual	L	OCT 2024	Santosh Bhadran	Ron Barker



CASING DATA		Flex Mill PN:	Dimensional Parameters									
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F/N in.	G in.	L in.	Mill OD Type
10 3/4	32.75	2158735	Nominal	6.50	7.30	9.875	27.00	6.50	20.00	3.00	114.80	Rough
			MIN	6.47	6.80	9.875	12.00	6.47	12.00	2.97	91.80	
			MAX	6.53	7.80	9.890	27.50	6.53	20.50	3.03	115.30	
	40.5 to 45.5	2158737	Nominal	6.50	7.30	9.750	27.00	6.50	20.00	3.00	114.80	Rough
			MIN	6.47	6.80	9.750	12.00	6.47	12.00	2.97	91.80	
			MAX	6.53	7.80	9.765	27.50	6.53	20.50	3.03	115.30	
	51	2158741	Nominal	6.50	7.30	9.625	27.00	6.50	20.00	3.00	114.80	Rough
			MIN	6.47	6.80	9.625	12.00	6.47	12.00	2.97	91.80	
			MAX	6.53	7.80	9.640	27.50	6.53	20.50	3.03	115.30	
	55.5	2158743	Nominal	6.50	7.30	9.500	27.00	6.50	20.00	3.00	114.80	Rough
			MIN	6.47	6.80	9.500	12.00	6.47	12.00	2.97	91.80	
			MAX	6.53	7.80	9.515	27.50	6.53	20.50	3.03	115.30	
	60-65	2158745	Nominal	6.50	7.30	9.375	27.00	6.50	20.00	3.00	114.80	Rough
			MIN	6.47	6.80	9.375	12.00	6.47	12.00	2.97	91.80	
			MAX	6.53	7.80	9.390	27.50	6.53	20.50	3.03	115.30	

Carbide Application Acceptance Criteria

1. The crushed carbide grains shall be protruding and not merged in the weld media
2. The Mill OD shall be rough and inspector shall feel the sharp edges by hand
3. Insert faces and edges shall be clear and clean of brass (not covered)
4. All Inserts shall be free from damaged or broken edges
5. Carbide Inserts on Mill OD are chip breaker negative rake face

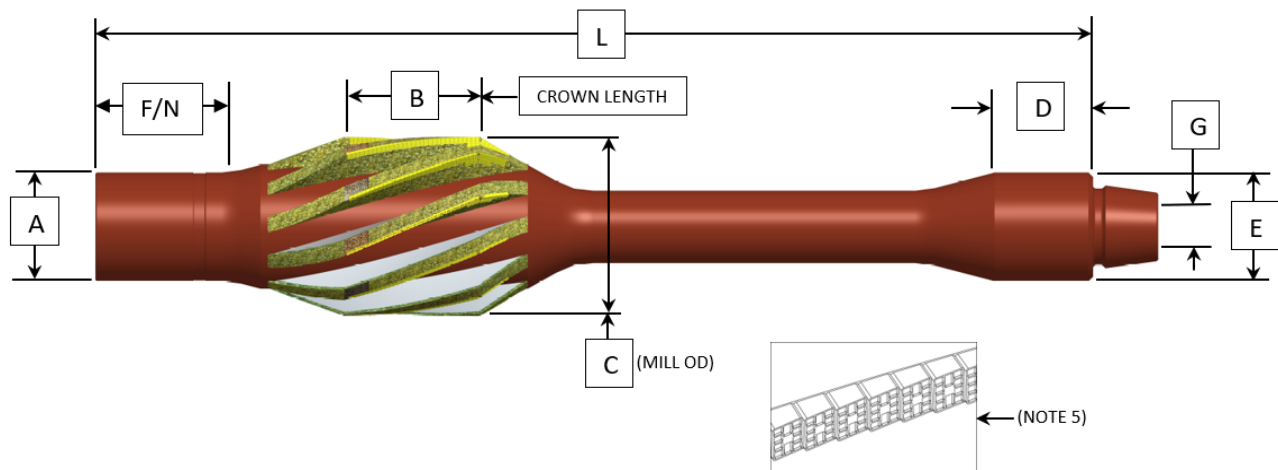


CASING DATA		Flex Mill PN:	Dimensional Parameters									
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F/N in.	G in.	L in.	Mill OD Type
11 3/4	38	2263734	Nominal	8.00	5.13	10.875	26.50	7.50	20.00	3.00	114.50	Rough
			MIN	7.97	4.62	10.875	12.00	7.47	12.00	2.97	92.00	
			MAX	8.03	5.62	10.890	27.00	7.53	20.50	3.03	115.00	
	42	2263735	Nominal	8.00	5.25	10.750	26.50	7.50	20.00	3.00	114.50	Rough
			MIN	7.97	4.75	10.750	12.00	7.47	12.00	2.97	92.00	
			MAX	8.03	5.75	10.765	27.00	7.53	20.50	3.03	115.00	
	47	2263736	Nominal	8.00	5.38	10.625	26.50	7.50	20.00	3.00	114.50	Rough
			MIN	7.97	4.88	10.625	12.00	7.47	12.00	2.97	92.00	
			MAX	8.03	5.88	10.640	27.00	7.53	20.50	3.03	115.00	
	54	2263739	Nominal	8.00	5.50	10.500	26.50	7.50	20.00	3.00	114.50	Rough
			MIN	7.97	5.00	10.500	12.00	7.47	12.00	2.97	92.00	
			MAX	8.03	6.00	10.515	27.00	7.53	20.50	3.03	115.00	
	60	2263734	Nominal	8.00	5.13	10.875	26.50	7.50	20.00	3.00	114.50	Rough
			MIN	7.97	4.62	10.875	12.00	7.47	12.00	2.97	92.00	
			MAX	8.03	5.62	10.890	27.00	7.53	20.50	3.03	115.00	

Carbide Application Acceptance Criteria

- 1. The crushed carbide grains shall be protruding and not merged in the weld media
- 2. The Mill OD shall be rough and inspector shall feel the sharp edges by hand
- 3. Insert faces and edges shall be clear and clean of brass (not covered)
- 4. All Inserts shall be free from damaged or broken edges
- 5. Carbide Inserts on Mill OD are chip breaker negative rake face

	23 of 44	QC Flex Mill Field Inspection Criteria					
DOCUMENT NUMBER	CLASSIFICATION	DOCUMENT LEVEL	REVISION	ISSUE DATE	PREPARED BY	APPROVAL	
GL-INTS-OEPS-L4-459	CONTROLLED	Technical Manual	L	OCT 2024	Santosh Bhadran	Ron Barker	

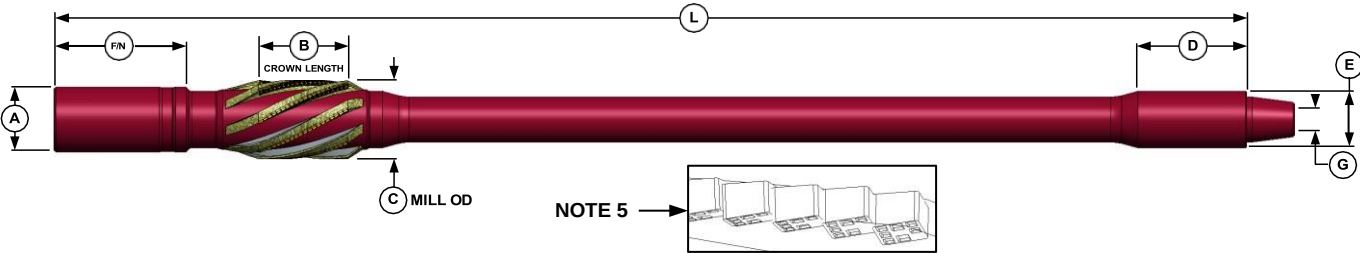


CASING DATA		Flex Mill PN:	Dimensional Parameters									
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F/N in.	G in.	L in.	Mill OD Type
13 3/8	48-72	2536426	Nominal	7.50	8.38	12.250	8.00	7.50	11.50	3.00	67.00	Rough
			MIN	7.47	7.88	12.250	6.00	7.47	10.00	2.90	63.50	
			MAX	7.53	8.88	12.265	8.50	7.53	12.00	3.10	67.50	
16	55-84	2582153	Nominal	9.00	10.92	14.750	8.00	9.00	10.20	4.00	80.63	Rough
			MIN	8.97	10.42	14.750	7.50	8.97	9.50	3.90	79.43	
			MAX	9.03	11.42	14.765	8.50	9.03	10.70	4.10	81.13	
	94.5-95	2572245	Nominal	9.00	11.60	14.500	8.00	9.00	10.20	4.00	80.63	Rough
			MIN	8.97	11.10	14.500	7.50	8.97	9.50	3.90	79.43	
			MAX	9.03	12.10	14.515	8.50	9.03	10.70	4.10	81.13	
18 5/8	78-94.5	739457	Nominal	9.00	9.00	17.500	9.70	9.00	11.50	4.00	93.20	Rough
			MIN	8.97	8.50	17.500	8.00	8.97	10.00	3.90	90.00	
			MAX	9.03	9.50	17.530	10.20	9.03	12.00	4.10	93.70	
	98-138	1142828	Nominal	9.00	10.38	17.000	9.70	9.00	11.50	4.00	93.20	Rough
			MIN	8.97	9.88	17.000	8.00	8.97	10.00	3.90	90.00	
			MAX	9.03	10.88	17.030	10.20	9.03	12.00	4.10	93.70	
20	90-187	739457	Nominal	9.00	9.00	17.500	9.70	9.00	11.50	4.00	93.20	Rough
			MIN	8.97	8.50	17.500	8.00	8.97	10.00	3.90	90.00	
			MAX	9.03	9.50	17.530	10.20	9.03	12.00	4.10	93.70	

Carbide Application Acceptance Criteria

1. The crushed carbide grains shall be protruding and not merged in the weld media
2. The Mill OD shall be rough and inspector shall feel the sharp edges by hand
3. Insert faces and edges shall be clear and clean of brass (not covered)
4. All Inserts shall be free from damaged or broken edges
5. Carbide Inserts on Mill OD are chip breaker negative rake face

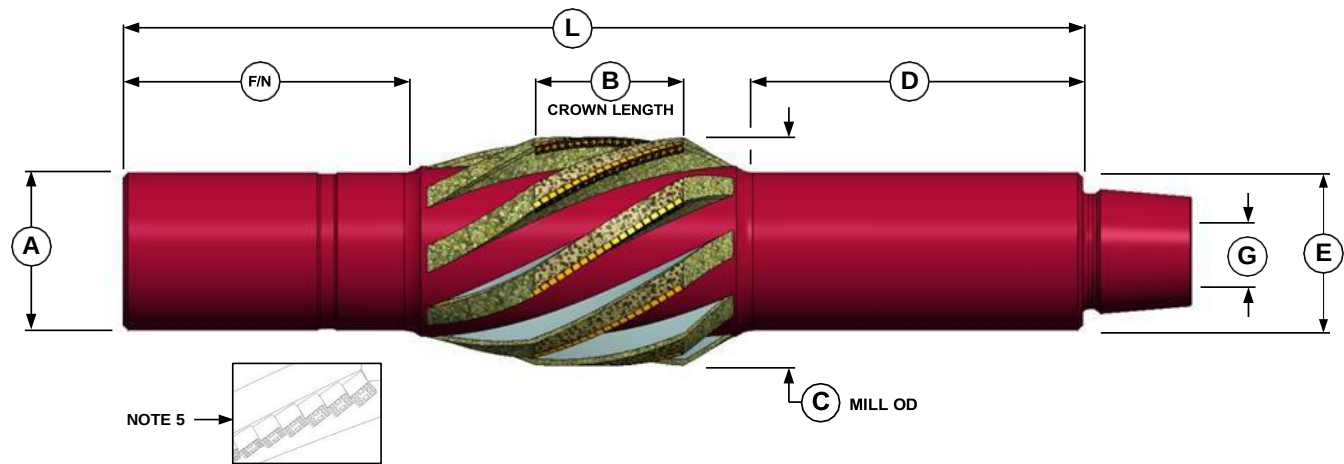
	24 of 44	SAQC Steering Mill Field Inspection Criteria				
DOCUMENT NUMBER	CLASSIFICATION	DOCUMENT LEVEL	REVISION	ISSUE DATE	PREPARED BY	APPROVAL
GL-INTS-OEPS-L4-459	CONTROLLED	Technical Manual	L	OCT 2024	Santosh Bhadran	Ron Barker



CASING DATA		Steering Mill PN:	Dimensional Parameters									
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F/N in.	G in.	L in.	Mill OD Type
7	20	2214762	Nominal	4.88	6.75	6.250	8.20	4.25	10.00	1.50	90.40	Smooth
	23.0 SD		MIN	4.85	6.25	6.250	5.50	4.25	5.50	1.47	83.20	
			MAX	4.91	7.25	6.265	8.70	4.28	10.50	1.53	90.90	
	23	2214763	Nominal	4.88	6.75	6.125	8.20	4.25	10.00	1.50	90.40	Smooth
	26		MIN	4.85	6.25	6.125	5.50	4.25	5.50	1.47	83.20	
	29.0 SD		MAX	4.91	7.25	6.140	8.70	4.28	10.50	1.53	90.90	
	29	2214764	Nominal	4.88	6.75	6.000	8.20	4.25	10.00	1.50	90.40	Smooth
			MIN	4.85	6.25	6.000	5.50	4.25	5.50	1.47	83.20	
			MAX	4.91	7.25	6.015	8.70	4.28	10.50	1.53	90.90	
	32	2214766	Nominal	4.88	6.75	5.875	8.20	4.25	10.00	1.50	90.40	Smooth
			MIN	4.85	6.25	5.875	5.50	4.25	5.50	1.47	83.20	
			MAX	4.91	7.25	5.890	8.70	4.28	10.50	1.53	90.90	
	32.0 SD	2214764	Nominal	4.88	6.75	6.000	8.20	4.25	10.00	1.50	90.40	Smooth
			MIN	4.85	6.25	6.000	5.50	4.25	5.50	1.47	83.20	
			MAX	4.91	7.25	6.015	8.70	4.28	10.50	1.53	90.90	
	32 lb SCL	2214767	Nominal	4.88	6.75	5.840	8.20	4.25	10.00	1.50	90.40	Smooth
			MIN	4.85	6.25	5.840	5.50	4.25	5.50	1.47	83.20	
			MAX	4.91	7.25	5.855	8.70	4.28	10.50	1.53	90.90	
	35	2214766	Nominal	4.88	6.75	5.875	8.20	4.25	10.00	1.50	90.40	Smooth
			MIN	4.85	6.25	5.875	5.50	4.25	5.50	1.47	83.20	
			MAX	4.91	7.25	5.890	8.70	4.28	10.50	1.53	90.90	
	38	2214768	Nominal	4.88	6.75	5.750	8.20	4.25	10.00	1.50	90.40	Smooth
			MIN	4.85	6.25	5.750	5.50	4.25	5.50	1.47	83.20	
			MAX	4.91	7.25	5.765	8.70	4.28	10.50	1.53	90.90	

Carbide Application Acceptance Criteria

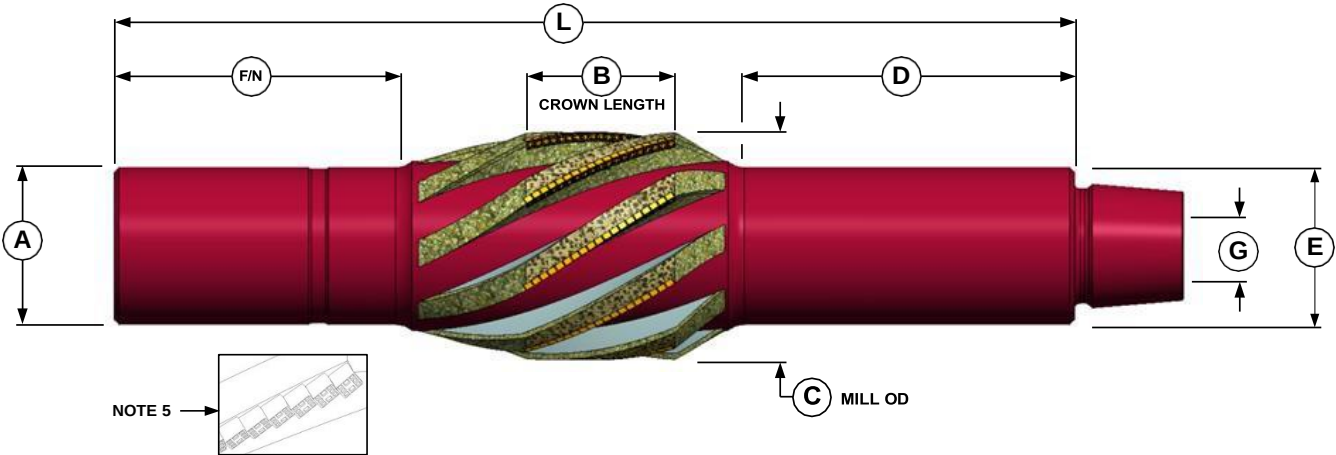
1. The crushed carbide grains shall be protruding and not merged in the weld media
2. The Mill OD shall be smooth finish
3. Insert faces and edges shall be clear and clean of brass (not covered)
4. All Inserts shall be free from damaged or broken edges
5. Carbide Inserts on Mill OD are chip breaker, negative rake face



CASING DATA		Steering Mill PN:	Dimensional Parameters									
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F/N in.	G in.	L in.	Mill OD Type
9 5/8	32.3	1916006	Nominal	6.63	7.56	8.875	9.50	6.25	12.50	2.25	34.80	Smooth
			MIN	6.60	7.16	8.875	8.00	6.22	8.00	2.22	28.80	
			MAX	6.66	8.16	8.890	10.00	6.28	13.00	2.28	35.30	
	36	1916007	Nominal	6.63	7.56	8.750	9.50	6.25	12.50	2.25	34.80	Smooth
			MIN	6.60	7.16	8.750	8.00	6.22	8.00	2.22	28.80	
			MAX	6.66	8.16	8.765	10.00	6.28	13.00	2.28	35.30	
	40	1916008	Nominal	6.63	7.56	8.625	9.50	6.25	12.50	2.25	34.80	Smooth
	43.5 SD		MIN	6.60	7.16	8.625	8.00	6.22	8.00	2.22	28.80	
			MAX	6.66	8.16	8.640	10.00	6.28	13.00	2.28	35.30	
	43.5	1916011	Nominal	6.63	7.56	8.500	9.50	6.25	12.50	2.25	34.80	Smooth
	47		MIN	6.60	7.16	8.500	8.00	6.22	8.00	2.22	28.80	
	53.5 SD		MAX	6.66	8.16	8.515	10.00	6.28	13.00	2.28	35.30	
	53.5	1916012	Nominal	6.63	7.56	8.375	9.50	6.25	12.50	2.25	34.80	Smooth
			MIN	6.60	7.16	8.375	8.00	6.22	8.00	2.22	28.80	
			MAX	6.66	8.16	8.390	10.00	6.28	13.00	2.28	35.30	
	58.4	1916013	Nominal	6.63	7.56	8.250	9.50	6.25	12.50	2.25	34.80	Smooth
			MIN	6.60	7.16	8.250	8.00	6.22	8.00	2.22	28.80	
			MAX	6.66	8.16	8.265	10.00	6.28	13.00	2.28	35.30	

Carbide Application Acceptance Criteria

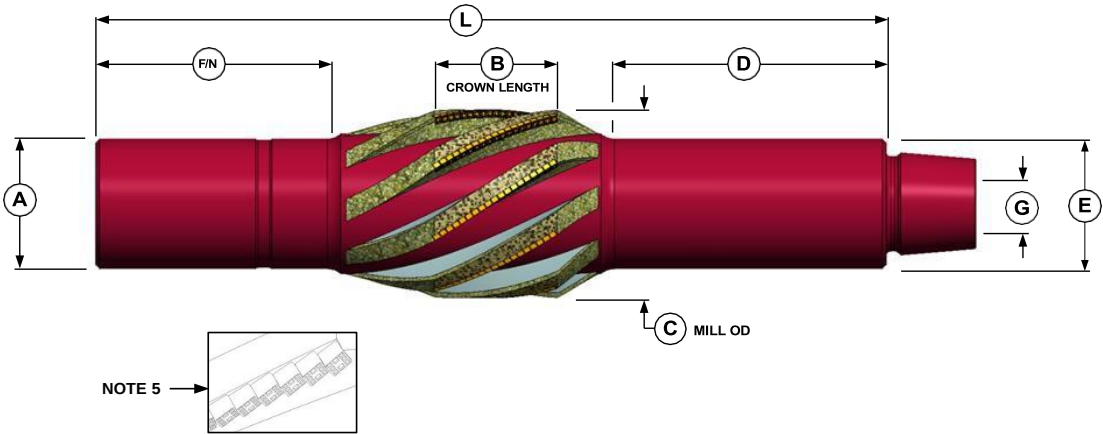
1. The crushed carbide grains shall be protruding and not merged in the weld media
2. The Mill OD shall be smooth finish
3. Insert faces and edges shall be clear and clean of brass (not covered)
4. All Inserts shall be free from damaged or broken edges
5. Carbide Inserts on Mill OD are chip breaker, negative rake face



CASING DATA		Steering Mill PN:	Dimensional Parameters									
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F/N in.	G in.	L in.	Mill OD Type
10 3/4	32.75	2189736	Nominal	6.50	6.14	9.875	13.60	6.50	11.60	3.00	39.50	Smooth
			MIN	6.47	5.64	9.875	10.00	6.47	8.00	2.97	32.30	
			MAX	6.53	6.64	9.890	14.40	6.53	12.10	3.03	40.00	
	40.5 to 45.5	2189730	Nominal	6.50	6.14	9.750	13.60	6.50	11.60	3.00	39.50	Smooth
			MIN	6.47	5.64	9.750	10.00	6.47	8.00	2.97	32.30	
			MAX	6.53	6.64	9.765	14.40	6.53	12.10	3.03	40.00	
	51	2189728	Nominal	6.50	6.14	9.625	13.60	6.50	11.60	3.00	39.50	Smooth
			MIN	6.47	5.64	9.625	10.00	6.47	8.00	2.97	32.30	
			MAX	6.53	6.64	9.640	14.40	6.53	12.10	3.03	40.00	
	55.5	2189719	Nominal	6.50	6.14	9.500	13.60	6.50	11.60	3.00	39.50	Smooth
			MIN	6.47	5.64	9.500	10.00	6.47	8.00	2.97	32.30	
			MAX	6.53	6.64	9.515	14.40	6.53	12.10	3.03	40.00	
	60 to 65	2217826	Nominal	6.50	6.14	9.375	13.60	6.50	11.60	3.00	39.50	Smooth
			MIN	6.47	5.64	9.375	10.00	6.47	8.00	2.97	32.30	
			MAX	6.53	6.64	9.390	14.40	6.53	12.10	3.03	40.00	

Carbide Application Acceptance Criteria

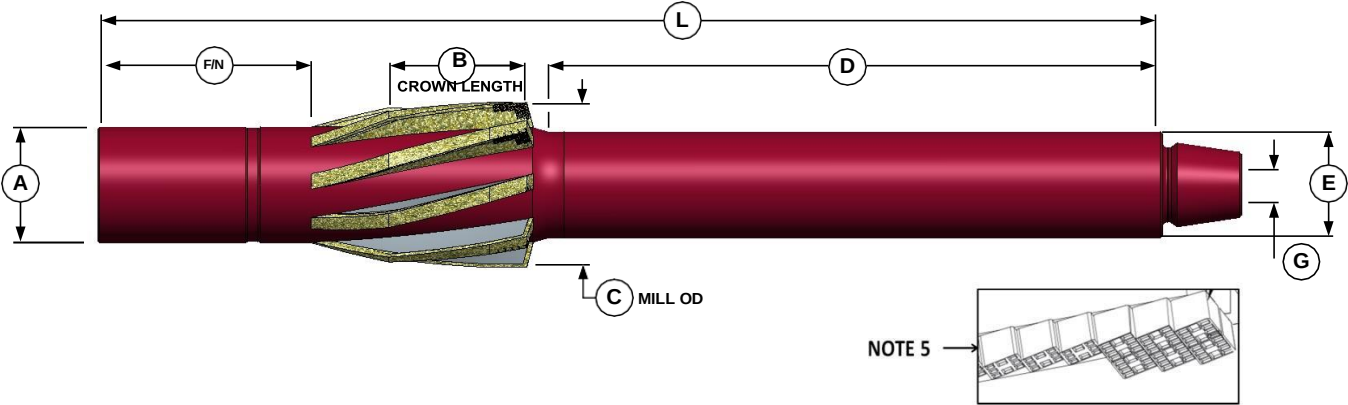
1. The crushed carbide grains shall be protruding and not merged in the weld media
2. The Mill OD shall be smooth finish
3. Insert faces and edges shall be clear and clean of brass (not covered)
4. All Inserts shall be free from damaged or broken edges
5. Carbide Inserts on Mill OD are chip breaker, negative rake face



CASING DATA		Steering Mill PN:	Dimensional Parameters									
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F/N in.	G in.	L in.	Mill OD Type
11 3/4	38	795823	Nominal	8.00	6.06	10.875	13.25	7.50	11.63	3.00	39.10	Smooth
			MIN	7.97	5.56	10.875	10.00	7.47	11.00	2.97	35.22	
			MAX	8.03	6.56	10.890	13.75	7.53	12.13	3.03	39.60	
	42	795822	Nominal	8.00	6.06	10.750	13.25	7.50	11.63	3.00	39.10	Smooth
			MIN	7.97	5.56	10.750	10.00	7.47	11.00	2.97	35.22	
			MAX	8.03	6.56	10.765	13.75	7.53	12.13	3.03	39.60	
	54	795821	Nominal	8.00	6.06	10.625	13.25	7.50	11.63	3.00	39.10	Smooth
			MIN	7.97	5.56	10.625	10.00	7.47	11.00	2.97	35.22	
			MAX	8.03	6.56	10.640	13.75	7.53	12.13	3.03	39.60	
	60	786226	Nominal	8.00	6.06	10.500	13.25	7.50	11.63	3.00	39.10	Smooth
			MIN	7.97	5.56	10.500	10.00	7.47	11.00	2.97	35.22	
			MAX	8.03	6.56	10.515	13.75	7.53	12.13	3.03	39.60	
13 3/8	48 to 72	2022169	Nominal	8.00	6.23	12.250	11.25	7.50	12.10	3.00	43.60	Smooth
			MIN	7.97	5.73	12.250	8.00	7.47	11.00	2.97	39.25	
			MAX	8.03	6.73	12.265	11.75	7.53	12.60	3.03	44.10	
	48 to 72 SPCL	2135958	Nominal	8.00	6.23	12.250	11.25	7.50	12.10	3.00	43.60	Smooth
			MIN	7.97	5.73	12.240	8.00	7.47	11.00	2.97	39.25	
			MAX	8.03	6.73	12.250	11.75	7.53	12.60	3.03	44.10	
	72	2620047	Nominal	8.00	6.23	12.125	11.25	7.50	12.10	3.00	43.60	Smooth
			MIN	7.97	5.73	12.125	8.00	7.47	11.00	2.97	39.25	
			MAX	8.03	6.73	12.140	11.75	7.53	12.60	3.03	44.10	

Carbide Application Acceptance Criteria

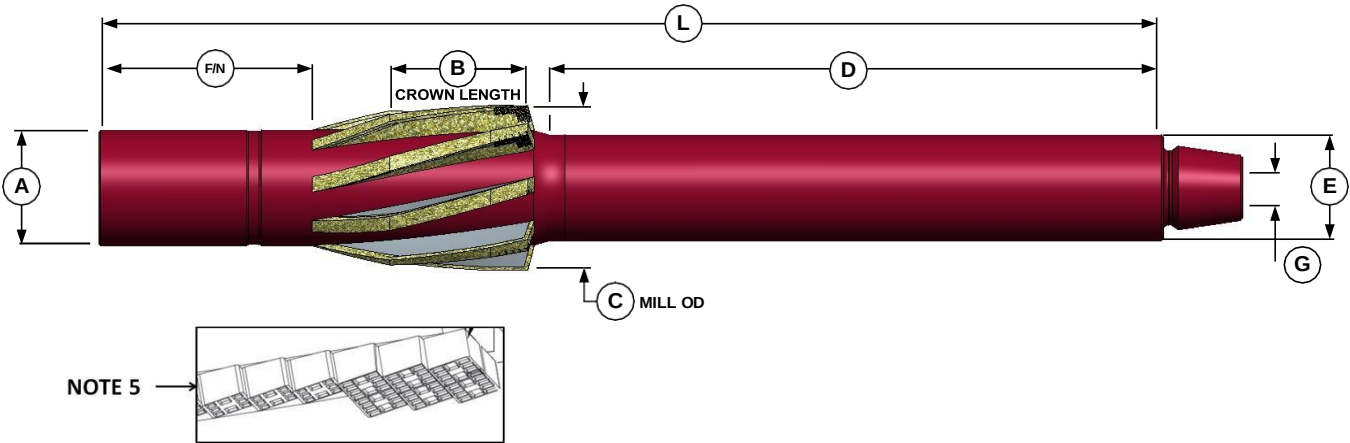
1. The crushed carbide grains shall be protruding and not merged in the weld media
2. The Mill OD shall be smooth finish
3. Insert faces and edges shall be clear and clean of brass (not covered)
4. All Inserts shall be free from damaged or broken edges
5. Carbide Inserts on Mill OD are chip breaker, negative rake face



CASING DATA		Secondary Mill PN:	Dimensional Parameters									
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F/N in.	G in.	L in.	Mill OD Type
7	20	788453	Nominal	4.25	5.97	6.250	21.50	4.25	9.96	1.50	43.18	Rough
	23.0 SD		MIN	4.22	5.47	6.250	19.00	4.22	8.00	1.47	38.72	
			MAX	4.28	6.47	6.265	22.00	4.28	10.46	1.53	43.68	
	23	788454	Nominal	4.25	5.97	6.125	21.50	4.25	9.96	1.50	43.18	Rough
	26		MIN	4.22	5.47	6.125	19.00	4.22	8.00	1.47	38.72	
	29.0 SD		MAX	4.28	6.47	6.140	22.00	4.28	10.46	1.53	43.68	
	29	788495	Nominal	4.25	5.97	6.000	21.50	4.25	9.96	1.50	43.18	Rough
			MIN	4.22	5.47	6.000	19.00	4.22	8.00	1.47	38.72	
			MAX	4.28	6.47	6.015	22.00	4.28	10.46	1.53	43.68	
	32	788496	Nominal	4.25	5.97	5.875	21.50	4.25	9.96	1.50	43.18	Rough
			MIN	4.22	5.47	5.875	19.00	4.22	8.00	1.47	38.72	
			MAX	4.28	6.47	5.890	22.00	4.28	10.46	1.53	43.68	
	32.0 SD	788495	Nominal	4.25	5.97	6.000	21.50	4.25	9.96	1.50	43.18	Rough
			MIN	4.22	5.47	6.000	19.00	4.22	8.00	1.47	38.72	
			MAX	4.28	6.47	6.015	22.00	4.28	10.46	1.53	43.68	
	32 lb SCL	773882	Nominal	4.25	5.97	5.840	21.50	4.25	9.96	1.50	43.18	Rough
			MIN	4.22	5.47	5.840	19.00	4.22	8.00	1.47	38.72	
			MAX	4.28	6.47	5.855	22.00	4.28	10.46	1.53	43.68	
	35	788496	Nominal	4.25	5.97	5.875	21.50	4.25	9.96	1.50	43.18	Rough
			MIN	4.22	5.47	5.875	19.00	4.22	8.00	1.47	38.72	
			MAX	4.28	6.47	5.890	22.00	4.28	10.46	1.53	43.68	
	38	788498	Nominal	4.25	5.97	5.750	21.50	4.25	9.96	1.50	43.18	Rough
			MIN	4.22	5.47	5.750	19.00	4.22	8.00	1.47	38.72	
			MAX	4.28	6.47	5.765	22.00	4.28	10.46	1.53	43.68	

Carbide Application Acceptance Criteria

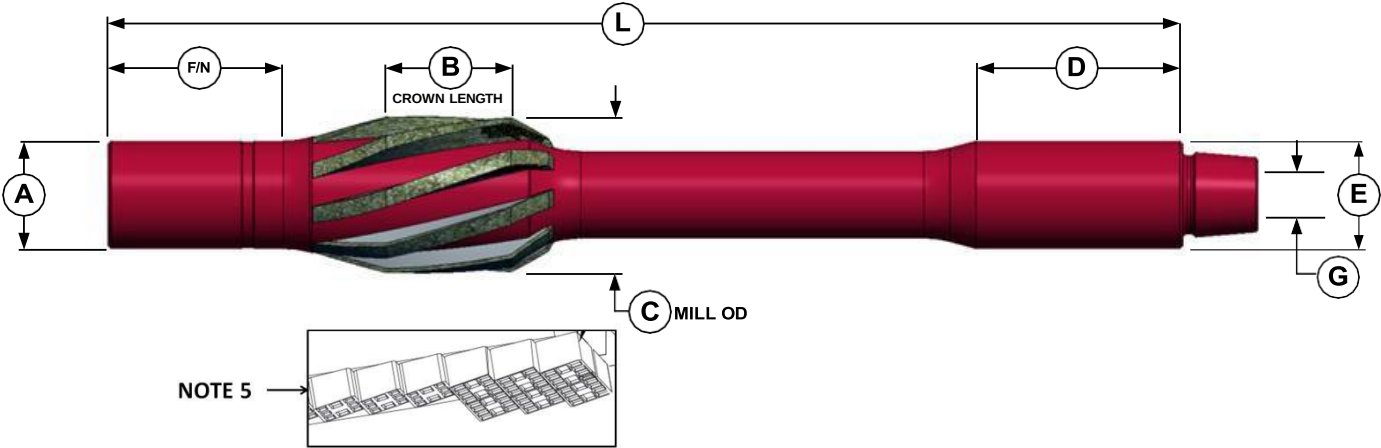
1. The crushed carbide grains shall be protruding and not merged in the weld media
2. The Mill OD shall be rough and inspector shall feel the sharp edges by hand
3. Insert faces and edges shall be clear and clean of brass (not covered)
4. All Inserts shall be free from damaged or broken edges
5. Carbide Inserts on Mill OD are chip breaker negative rake face



CASING DATA		Secondary Mill PN:	Dimensional Parameters									
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F/N in.	G in.	L in.	Mill OD Type
9 5/8	32.3	1268112	Nominal	6.25	7.46	8.875	32.90	5.75	12.50	2.25	57.65	Rough
			MIN	6.22	6.96	8.875	30.00	5.72	10.00	2.22	52.25	
			MAX	6.28	7.96	8.890	33.40	5.78	13.00	2.28	58.15	
	36	1269208	Nominal	6.25	7.46	8.750	32.90	5.75	12.50	2.25	57.65	Rough
			MIN	6.22	6.96	8.750	30.00	5.72	10.00	2.22	52.25	
			MAX	6.28	7.96	8.765	33.40	5.78	13.00	2.28	58.15	
	40 43.5 SD	808132	Nominal	6.25	7.46	8.625	32.90	5.75	12.50	2.25	57.65	Rough
			MIN	6.22	6.96	8.625	30.00	5.72	10.00	2.22	52.25	
			MAX	6.28	7.96	8.640	33.40	5.78	13.00	2.28	58.15	
	43.5 47 53.5 SD	126500	Nominal	6.25	7.46	8.500	32.90	5.75	12.50	2.25	57.65	Rough
			MIN	6.22	6.96	8.500	30.00	5.72	10.00	2.22	52.25	
			MAX	6.28	7.96	8.515	33.40	5.78	13.00	2.28	58.15	
	53.5 58.4	1269210	Nominal	6.25	7.46	8.375	32.90	5.75	12.50	2.25	57.65	Rough
			MIN	6.22	6.96	8.375	30.00	5.72	10.00	2.22	52.25	
			MAX	6.28	7.96	8.390	33.40	5.78	13.00	2.28	58.15	
	58.4	1276879	Nominal	6.25	7.46	8.250	32.90	5.75	12.50	2.25	57.65	Rough
			MIN	6.22	6.96	8.250	30.00	5.72	10.00	2.22	52.25	
			MAX	6.28	7.96	8.265	33.40	5.78	13.00	2.28	58.15	

Carbide Application Acceptance Criteria

- 1. The crushed carbide grains shall be protruding and not merged in the weld media
- 2. The Mill OD shall be rough and inspector shall feel the sharp edges by hand
- 3. Insert faces and edges shall be clear and clean of brass (not covered)
- 4. All Inserts shall be free from damaged or broken edges
- 5. Carbide Inserts on Mill OD are chip breaker negative rake face

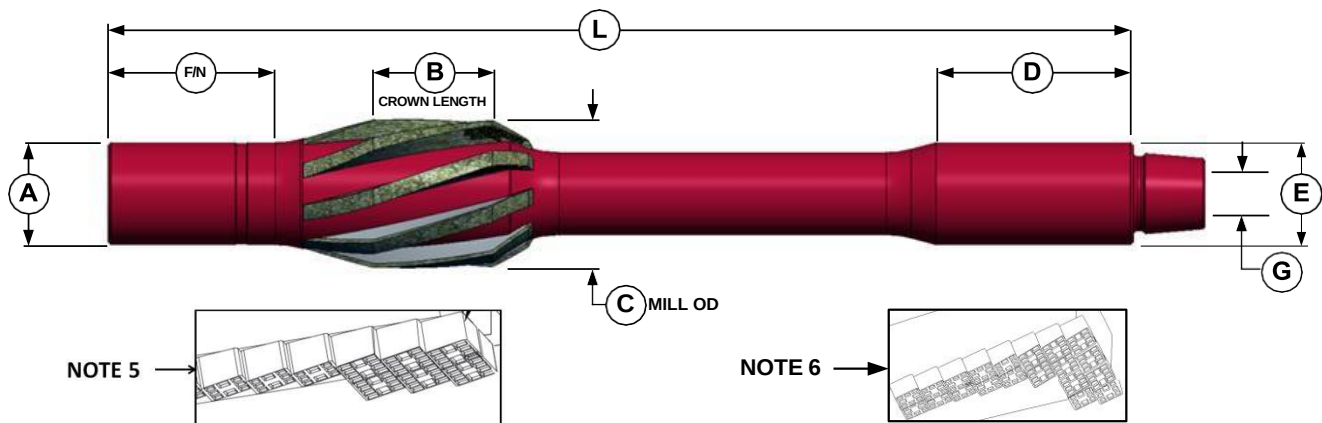


CASING DATA		Secondary Mill PN:	Dimensional Parameters									
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F/N in.	G in.	L in.	Mill OD Type
10 3/4	32.75	881398	Nominal	6.50	7.50	9.875	12.40	6.50	10.50	3.00	64.50	Rough
			MIN	6.47	7.00	9.875	10.00	6.47	9.00	2.90	60.60	
			MAX	6.53	8.00	9.890	12.90	6.53	11.00	3.10	65.00	
	40.5 to 45.5	881397	Nominal	6.50	7.50	9.750	12.40	6.50	10.50	3.00	64.50	Rough
			MIN	6.47	7.00	9.750	10.00	6.47	9.00	2.90	60.60	
			MAX	6.53	8.00	9.765	12.90	6.53	11.00	3.10	65.00	
	51	881395	Nominal	6.50	7.50	9.625	12.40	6.50	10.50	3.00	64.50	Rough
			MIN	6.47	7.00	9.625	10.00	6.47	9.00	2.90	60.60	
			MAX	6.53	8.00	9.640	12.90	6.53	11.00	3.10	65.00	
	55.5	881394	Nominal	6.50	7.50	9.500	12.40	6.50	10.50	3.00	64.50	Rough
			MIN	6.47	7.00	9.500	10.00	6.47	9.00	2.90	60.60	
			MAX	6.53	8.00	9.515	12.90	6.53	11.00	3.10	65.00	
	60 to 65	881408	Nominal	6.50	7.50	9.375	12.40	6.50	10.50	3.00	64.50	Rough
			MIN	6.47	7.00	9.375	10.00	6.47	9.00	2.90	60.60	
			MAX	6.53	8.00	9.390	12.90	6.53	11.00	3.10	65.00	

Carbide Application Acceptance Criteria

1. The crushed carbide grains shall be protruding and not merged in the weld media
2. The Mill OD shall be rough and inspector shall feel the sharp edges by hand
3. Insert faces and edges shall be clear and clean of brass (not covered)
4. All Inserts shall be free from damaged or broken edges
5. Carbide Inserts on Mill OD are chip breaker negative rake face

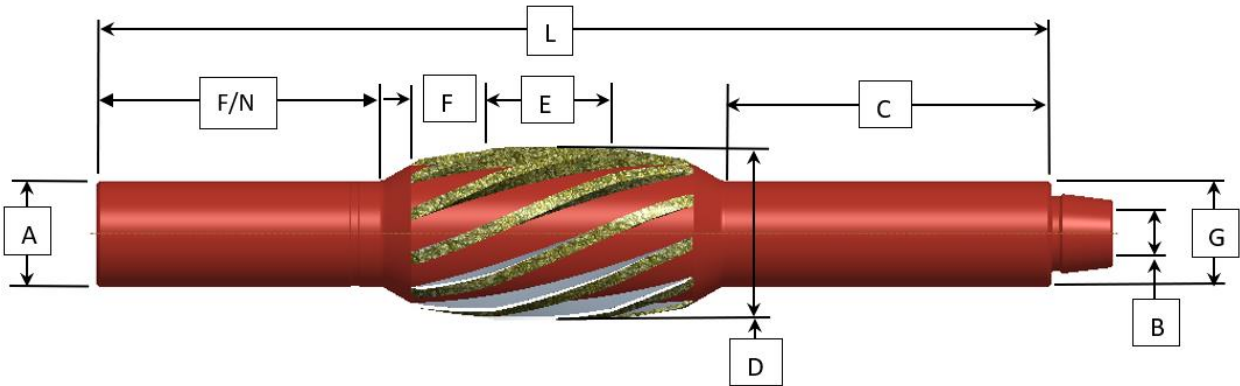
	31 of 44	SAQC Secondary Mill Field Inspection Criteria				
DOCUMENT NUMBER	CLASSIFICATION	DOCUMENT LEVEL	REVISION	ISSUE DATE	PREPARED BY	APPROVAL
GL-INTS-OEPS-L4-459	CONTROLLED	Technical Manual	L	OCT 2024	Santosh Bhadran	Ron Barker



CASING DATA		Secondary Mill PN:	Dimensional Parameters									
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F/N in.	G in.	L in.	Mill OD Type
11 3/4	38	795820	Nominal	7.50	7.13	10.875	11.00	7.50	11.75	3.00	71.00	Rough
			MIN	7.47	6.63	10.875	8.00	7.47	10.00	2.97	66.25	
			MAX	7.53	7.63	10.890	11.50	7.53	12.25	3.03	71.50	
	42	795818	Nominal	7.50	7.13	10.750	11.00	7.50	11.75	3.00	71.00	Rough
			MIN	7.47	6.63	10.750	8.00	7.47	10.00	2.97	66.25	
			MAX	7.53	7.63	10.765	11.50	7.53	12.25	3.03	71.50	
	54	795817	Nominal	7.50	7.13	10.625	11.00	7.50	11.75	3.00	71.00	Rough
			MIN	7.47	6.63	10.625	8.00	7.47	10.00	2.97	66.25	
			MAX	7.53	7.63	10.640	11.50	7.53	12.25	3.03	71.50	
13 3/8	60	786224	Nominal	7.50	7.13	10.500	11.00	7.50	11.75	3.00	71.00	Rough
			MIN	7.47	6.63	10.500	8.00	7.47	10.00	2.97	66.25	
			MAX	7.53	7.63	10.515	11.50	7.53	12.25	3.03	71.50	
	48 to 72	2045376	Nominal	7.50	10.30	12.250	14.60	7.50	11.63	3.00	87.50	Rough
			MIN	7.47	9.80	12.250	10.00	7.47	10.00	2.97	81.27	
			MAX	7.53	10.80	12.265	15.10	7.53	12.13	3.03	88.00	
	48 to 72 SPCL	2135938	Nominal	7.50	10.30	12.250	14.60	7.50	11.63	3.00	87.50	Rough
			MIN	7.47	9.80	12.240	10.00	7.47	10.00	2.97	81.27	
			MAX	7.53	10.80	12.250	15.10	7.53	12.13	3.03	88.00	
	72	2620037	Nominal	7.50	10.30	12.125	14.60	7.50	11.63	3.00	87.50	Rough
			MIN	7.47	9.80	12.125	10.00	7.47	10.00	2.97	81.27	
			MAX	7.53	10.80	12.140	15.10	7.53	12.13	3.03	88.00	

Carbide Application Acceptance Criteria

1. The crushed carbide grains shall be protruding and not merged in the weld media
2. The Mill OD shall be rough and inspector shall feel the sharp edges by hand
3. Insert faces and edges shall be clear and clean of brass (not covered)
4. All Inserts shall be free from damaged or broken edges
5. Carbide Inserts on Mill OD of 11-3/4 CSG Secondary Mills are chip breaker negative rake face
6. Carbide Inserts on Mill OD of 13-3/8 CSG Secondary Mills are chip breaker negative rake face

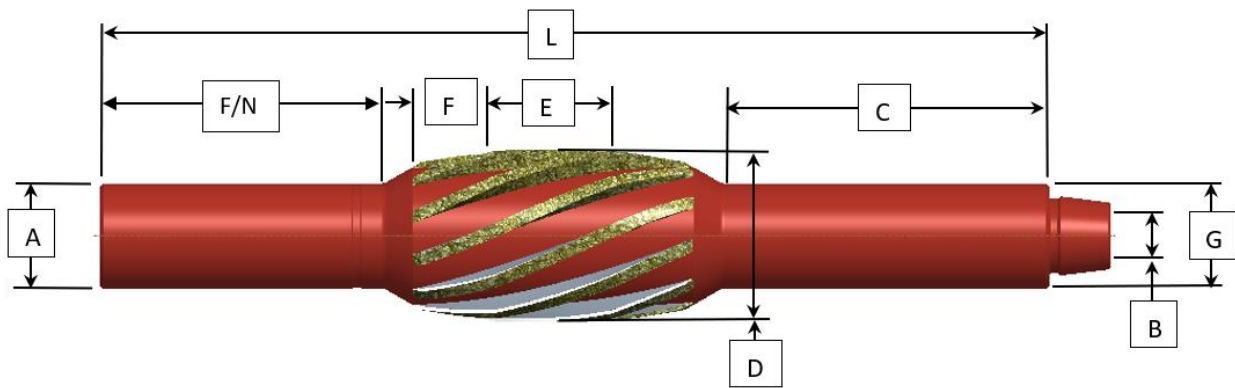


CASING DATA		W/melon Mill PN:	Dimensional Parameters										
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F in.	G in.	F/N in.	L in.	Mill OD Type
7	29 - 32 SD 45.5	2262806	Nominal	4.25	1.50	22.00	6.00	12.00	6.00	4.25	22.00	68.68	Rough
			MIN	4.22	1.47	9.00	5.97	10.00	6.00	4.22	12.00	45.68	
			MAX	4.28	1.56	22.50	6.03	12.00	7.00	4.28	22.50	69.68	
	23 - 29	2323513	Nominal	4.25	1.50	22.00	6.13	12.00	6.00	4.25	22.00	68.68	Rough
			MIN	4.22	1.47	9.00	6.10	10.00	6.00	4.22	12.00	45.68	
			MAX	4.28	1.56	22.50	6.16	12.00	7.00	4.28	22.50	69.68	
7 5/8	39	2303172	Nominal	4.25	1.50	22.00	6.50	12.00	6.00	4.25	22.00	75.00	Rough
			MIN	4.22	1.47	9.00	6.47	10.00	6.00	4.22	9.00	52.00	
			MAX	4.28	1.56	22.50	6.53	12.00	7.00	4.28	22.50	75.50	
9 5/8	53.5	2270070	Nominal	5.75	2.25	25.00	8.38	12.00	6.00	5.75	24.00	75.75	Rough
			MIN	5.72	2.22	9.00	8.35	10.00	6.00	5.72	12.00	47.75	
			MAX	5.78	2.31	25.50	8.41	12.00	7.00	5.78	24.50	76.75	
	43.5-47 53.5 SD	2168572	Nominal	5.75	2.25	25.00	8.50	12.00	6.00	5.75	24.00	75.75	Rough
			MIN	5.72	2.22	9.00	8.47	10.00	6.00	5.72	12.00	47.75	
			MAX	5.78	2.31	25.50	8.53	12.00	7.00	5.78	24.50	76.75	
	36	2582325	Nominal	5.75	2.25	25.00	8.75	12.00	6.00	5.75	24.00	75.75	Rough
			MIN	5.72	2.22	9.00	8.72	10.00	6.00	5.72	12.00	47.75	
			MAX	5.78	2.31	25.50	8.78	12.00	7.00	5.78	24.50	76.75	
10 3/4	40.5 - 45.5	2269137	Nominal	6.50	3.50	25.00	9.75	12.00	6.00	6.50	24.00	75.75	Rough
			MIN	6.47	3.47	9.00	9.72	10.00	6.00	6.47	12.00	47.75	
			MAX	6.53	3.53	25.50	9.78	12.00	7.00	6.53	25.00	76.75	
	55.5 - 60	2284552	Nominal	6.50	3.50	25.00	9.50	12.00	6.00	6.50	24.00	75.75	Rough
			MIN	6.47	3.47	9.00	9.47	10.00	6.00	6.47	12.00	47.75	
			MAX	6.53	3.53	25.50	9.53	12.00	7.00	6.53	25.00	76.75	
	60 - 65	2269136	Nominal	6.50	3.50	25.00	9.38	12.00	6.00	6.50	24.00	75.75	Rough
			MIN	6.47	3.47	9.00	9.35	10.00	6.00	6.47	12.00	47.75	
			MAX	6.53	3.53	25.50	9.41	12.00	7.00	6.53	25.00	76.75	

Carbide Application Acceptance Criteria

1. The crushed carbide grains shall be protruding and not merged in the weld media
2. The Mill OD shall be rough and inspector shall feel the sharp edges by hand

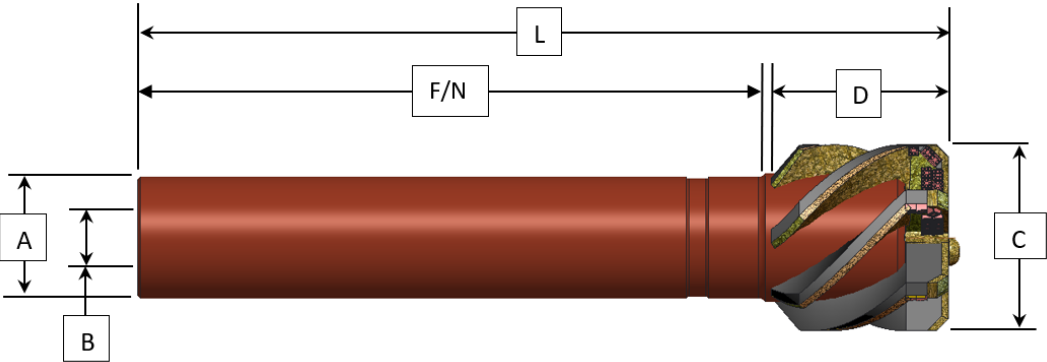
	33 of 44	Watermelon Mill Field Inspection Criteria					
DOCUMENT NUMBER	CLASSIFICATION	DOCUMENT LEVEL	REVISION	ISSUE DATE	PREPARED BY	APPROVAL	
GL-INTS-OEPS-L4-459	CONTROLLED	Technical Manual	L	OCT 2024	Santosh Bhadran	Ron Barker	



CASING DATA		W/melon Mill PN:	Dimensional Parameters										
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F in.	G in.	F/N in.	L in.	Mill OD Type
11 3/4	54	2264788	Nominal	8.00	3.50	25.00	10.63	12.00	6.00	8.00	24.00	73.60	Rough
			MIN	7.97	3.47	9.00	10.60	10.00	6.00	7.97	12.00	45.60	
			MAX	8.03	3.53	25.50	10.66	12.00	7.00	8.03	25.00	74.60	
	60	2264786	Nominal	8.00	3.50	25.00	10.50	12.00	6.00	8.00	24.00	73.60	Rough
			MIN	7.97	3.47	9.00	10.47	10.00	6.00	7.97	12.00	45.60	
			MAX	8.03	3.53	25.50	10.53	12.00	7.00	8.03	25.00	74.60	
13 3/8	48-72	2167778	Nominal	8.00	3.50	24.00	12.25	12.00	6.00	8.00	24.00	77.00	Rough
			MIN	7.97	3.47	9.00	12.22	10.00	6.00	7.97	12.00	50.00	
			MAX	8.03	3.53	24.50	12.28	12.00	7.00	8.03	25.00	78.00	
16	55-84	1189406	Nominal	9.00	4.00	28.00	14-75	10.00	7.00	9.00	24.00	81.00	Rough
			MIN	8.97	3.97	12.00	14.72	8.00	7.00	8.97	14.00	55.00	
			MAX	9.03	4.03	29.00	14.78	10.00	8.00	9.03	25.00	83.00	
	94.5-95	1189408	Nominal	9.00	4.00	28.00	14-50	10.00	7.00	9.00	24.00	81.00	Rough
			MIN	8.97	3.97	12.00	14.47	8.00	7.00	8.97	14.00	55.00	
			MAX	9.03	4.03	29.00	14.53	10.00	8.00	9.03	25.00	83.00	
20	90-187	2271934	Nominal	9.50	4.00	24.00	17.50	12.00	6.00	9.50	24.00	80.75	Rough
			MIN	9.47	3.97	12.00	17.47	10.00	6.00	9.47	14.00	58.75	
			MAX	9.53	4.03	25.00	17.53	12.00	7.00	9.53	24.50	81.75	

Carbide Application Acceptance Criteria

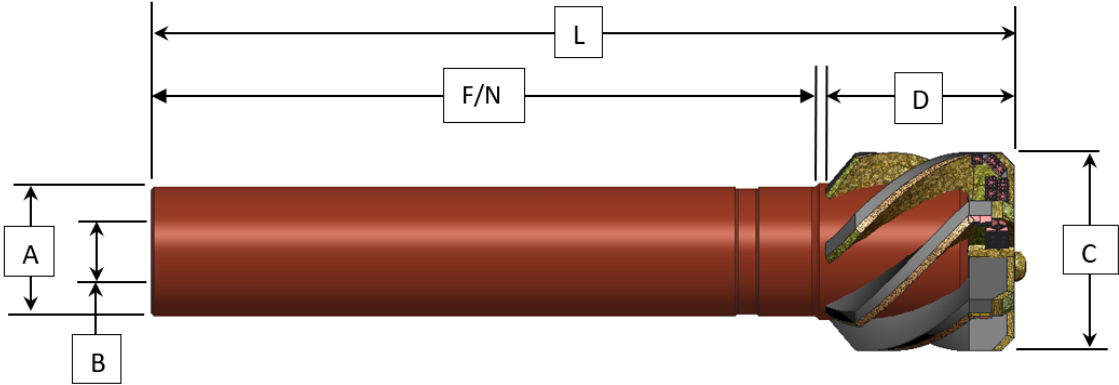
1. The crushed carbide grains shall be protruding and not merged in the weld media
2. The Mill OD shall be rough and inspector shall feel the sharp edges by hand



CASING DATA		Window Mill PN:	Dimensional Parameters							
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	F/N in.	L in.	Mill OD Type
7	29 & 32 SD	2263227	Nominal	4.25	1.50	6.00	6.25	22.00	28.45	Smooth
			MIN	4.22	1.47	5.97	5.75	12.00	18.45	
			MAX	4.28	1.53	6.03	6.75	22.50	28.95	
	23 & 29	2323004	Nominal	4.25	1.50	6.13	6.25	22.00	28.45	Smooth
			MIN	4.22	1.47	6.10	5.75	12.00	18.45	
			MAX	4.28	1.53	6.16	6.75	22.50	28.95	
7 5/8	39	2307884	Nominal	4.25	1.50	6.50	6.25	22.30	29.25	Smooth
			MIN	4.22	1.47	6.47	5.75	12.00	18.95	
			MAX	4.28	1.53	6.53	6.75	22.80	29.75	
9 5/8	53.5	1861640	Nominal	5.75	2.25	8.38	7.62	36.00	44.25	Smooth
			MIN	5.72	2.22	8.35	7.12	12.00	20.25	
			MAX	5.78	2.28	8.41	8.12	36.50	44.75	
	43.5-47 53.5 SD	1861648	Nominal	5.75	2.25	8.50	7.62	36.00	44.25	Smooth
			MIN	5.72	2.22	8.47	7.12	12.00	20.25	
			MAX	5.78	2.28	8.53	8.12	36.50	44.75	
	40	1861654	Nominal	5.75	2.25	8.63	7.62	36.00	44.25	Smooth
			MIN	5.72	2.22	8.60	7.12	12.00	20.25	
			MAX	5.78	2.28	8.66	8.12	36.50	44.75	
	36	1861656		5.75	2.25	8.75	7.62	36.00	44.25	Smooth
			MIN	5.72	2.22	8.72	7.12	12.00	20.25	
			MAX	5.78	2.28	8.78	8.12	36.50	44.75	
10 3/4	40.5 & 45.5	2237895	Nominal	6.50	3.75	9.75	7.50	36.00	44.75	Smooth
			MIN	6.47	3.72	9.78	7.00	12.00	20.75	
			MAX	6.53	3.78	9.72	8.00	36.50	45.05	
	55.5 & 60	2284837	Nominal	6.50	3.75	9.50	7.50	36.00	44.75	Smooth
			MIN	6.47	3.72	9.47	7.00	12.00	20.75	
			MAX	6.53	3.78	9.53	8.00	36.50	45.05	
	60 & 65	2237902	Nominal	6.50	3.75	9.38	7.50	36.00	44.75	Smooth
			MIN	6.47	3.72	9.35	7.00	12.00	20.75	
			MAX	6.53	3.78	9.41	8.00	36.50	45.05	

Carbide Application Acceptance Criteria

1. The crushed carbide grains shall be protruding and not merged in the weld media
2. The Mill OD shall be rough and inspector shall feel the sharp edges by hand

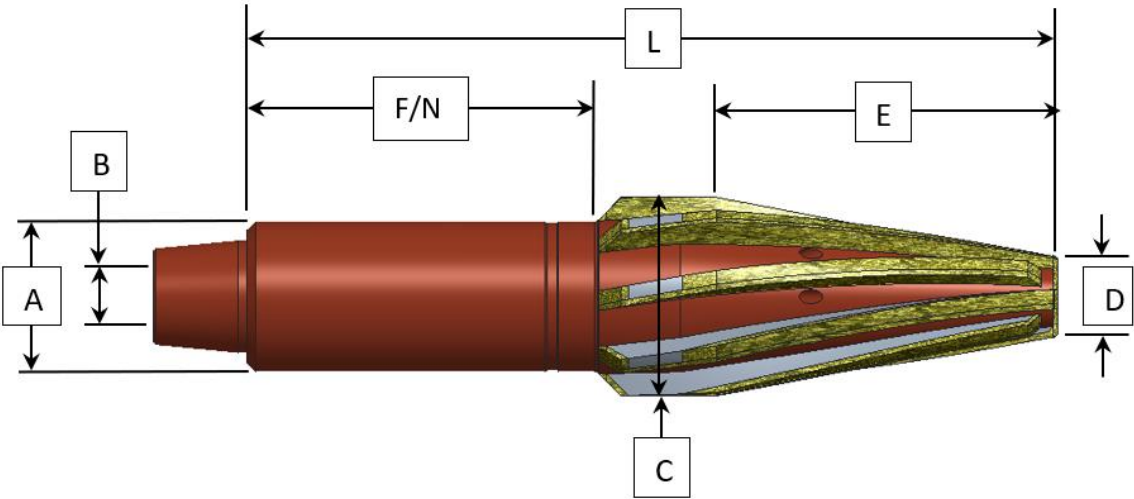


CASING DATA		Window Mill PN:	Dimensional Parameters							
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	F/N in.	L in.	Mill OD Type
11 3/4	54	1928568	Nominal	8.00	3.50	10.63	8.25	36.00	44.75	Smooth
			MIN	7.97	3.47	10.60	7.75	12.00	20.75	
			MAX	8.03	3.53	10.66	8.75	36.50	45.25	
	60	1929074	Nominal	8.00	3.50	10.50	8.25	36.00	44.75	Smooth
			MIN	7.97	3.47	10.47	7.75	12.00	20.75	
			MAX	8.03	3.53	10.53	8.75	36.50	45.25	
13 3/8	48-72	1804447	Nominal	8.00	3.50	12.25	8.40	41.00	51.55	Smooth
			MIN	7.97	3.47	12.22	7.90	12.00	22.55	
			MAX	8.03	3.53	12.28	8.90	41.50	52.05	
16	55-84	1921888	Nominal	9.00	4.00	14.75	16.22	36.00	53.75	Smooth
			MIN	8.97	3.97	14.72	15.72	14.00	31.75	
			MAX	9.03	4.03	14.78	16.72	36.50	54.25	
	94.5-95	2624891	Nominal	9.00	4.00	14.50	16.22	36.00	53.75	Smooth
			MIN	8.97	3.97	14.47	15.72	14.00	31.75	
			MAX	9.03	4.03	14.53	16.72	36.50	54.25	
20	90-187	1921891	Nominal	9.50	4.00	17.50	15.10	36.00	53.75	Smooth
			MIN	9.47	3.97	17.47	14.60	14.00	31.75	
			MAX	9.53	4.03	17.53	15.60	36.50	54.25	

Carbide Application Acceptance Criteria

1. The crushed carbide grains shall be protruding and not merged in the weld media
2. The Mill OD shall be rough and inspector shall feel the sharp edges by hand

	36 of 44	Taper Mill Field Inspection Criteria					
DOCUMENT NUMBER	CLASSIFICATION	DOCUMENT LEVEL	REVISION	ISSUE DATE	PREPARED BY	APPROVAL	
GL-INTS-OEPS-L4-459	CONTROLLED	Technical Manual	L	OCT 2024	Santosh Bhadran	Ron Barker	

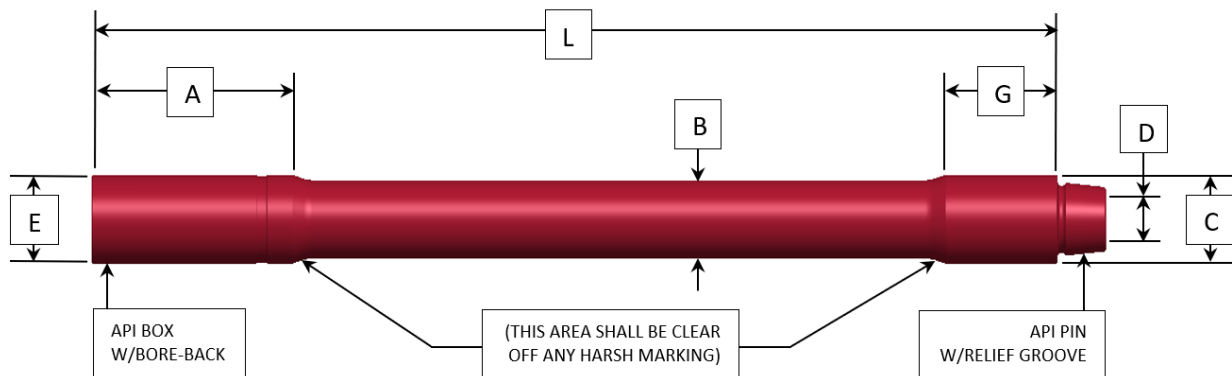


CASING DATA		Taper Mill PN:	Dimensional Parameters								Mill OD Type
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F/N in.	L in.	
7 5/8	39	2303575	Nominal	4.25	1.50	6.50	3.50	10.90	18.00	35.00	Smooth
			MIN	4.22	1.47	6.47	3.25	8.90	12.00	29.00	
			MAX	4.28	1.53	6.53	3.75	11.90	18.50	35.50	
10 3/4	60 & 65	2307897	Nominal	6.50	3.50	9.38	4.25	18.50	18.00	42.25	Smooth
			MIN	6.47	3.47	9.35	4.00	16.50	12.00	36.25	
			MAX	6.53	3.53	9.41	4.75	19.50	18.50	42.75	

Carbide Application Acceptance Criteria

1. The crushed carbide grains shall be protruding and not merged in the weld media
2. The Mill OD shall be rough and inspector shall feel the sharp edges by hand

	37 of 44	QC & SAQC Flex Mandrel Field Inspection Criteria				
DOCUMENT NUMBER	CLASSIFICATION	DOCUMENT LEVEL	REVISION	ISSUE DATE	PREPARED BY	APPROVAL
GL-INTS-OEPS-L4-459	CONTROLLED	Technical Manual	L	OCT 2024	Santosh Bhadran	Ron Barker



QUICKCUT FLEX MANDEL

CASING DATA		Flex Mandrel PN:	Dimensional Parameters							
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	L in.	G in.
13 3/8	48-72	735800	Nominal	15.00	5.75	7.75	3.00	7.75	143.50	7.50
			MIN	12.00	5.72	7.69	2.97	7.69	139.00	6.00
			MAX	15.13	5.78	7.78	3.03	7.78	143.75	7.62
16	55-84	760405	Nominal	35.00	6.50	9.00	4.00	9.00	236.25	10.50
18-5/8	78-138		MIN	18.00	6.47	8.94	3.97	8.94	216.75	8.00
20	90-187		MAX	35.13	6.53	9.03	4.03	9.03	236.50	10.62

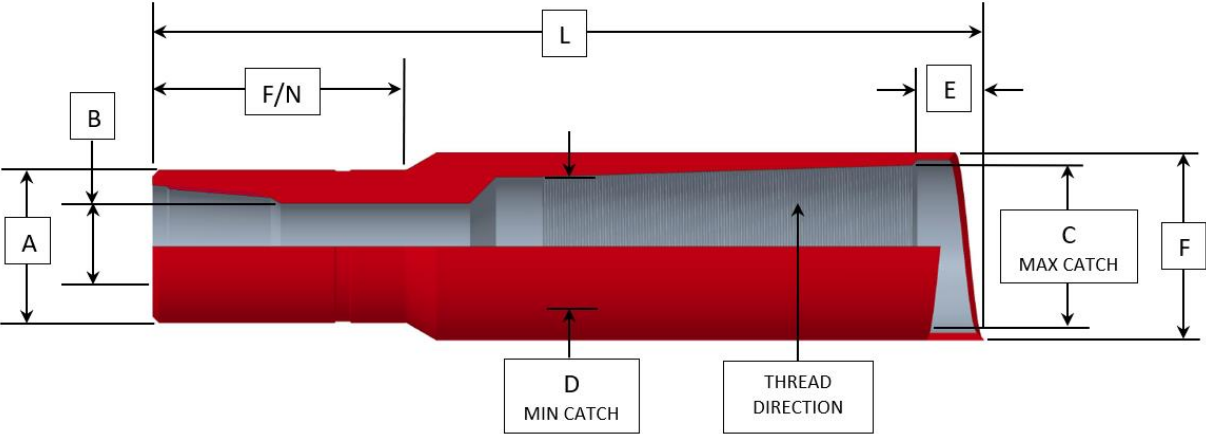
SHALLOW ANGLE QUICKCUT FLEX MANDEL

CASING DATA		Flex Mandrel PN:	Dimensional Parameters							
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F in.	G In.
9-5/8	43.5-53.5 SD	126448	Nominal	12.00	5.50	6.25	2.25	6.25	87.50	10.00
10-3/4	32.75-65		MIN	9.00	5.47	6.19	2.22	6.19	81.50	7.00
			MAX	12.13	5.53	6.28	2.28	6.28	87.75	10.13
11-3/4	38-60	735800	Nominal	15.00	5.75	7.75	3.00	7.75	143.50	7.50
13-3/8	48-72		MIN	12.00	5.72	7.69	2.97	7.69	139.00	6.00
			MAX	15.13	5.78	7.78	3.03	7.78	143.75	7.62

Notes:

1. The Flex Mandrel shall be inspected according to DS1 Vol.3 Cat 3-5 Latest Edition
2. All Thread Connection Shall have API SRG
3. All Thread Connection Shall be Cold Rolled as per DS1 Vol.3 Latest Edition
4. ID shall be Free of any wash out or visible damage and accessible
5. No Harsh Marking allowed on the upset/Transition areas
6. All other cutting, gouges and harsh marking follow DS1 Vol.3 criteria
7. All other Inspection/Acceptance Criteria for API DPs in DS1 Vol.3 shall be followed in addition to the above points

	38 of 44	Box tap/Die Collar Field Inspection Criteria				
DOCUMENT NUMBER	CLASSIFICATION	DOCUMENT LEVEL	REVISION	ISSUE DATE	PREPARED BY	APPROVAL
GL-INTS-OEPS-L4-459	CONTROLLED	Technical Manual	L	OCT 2024	Santosh Bhadran	Ron Barker

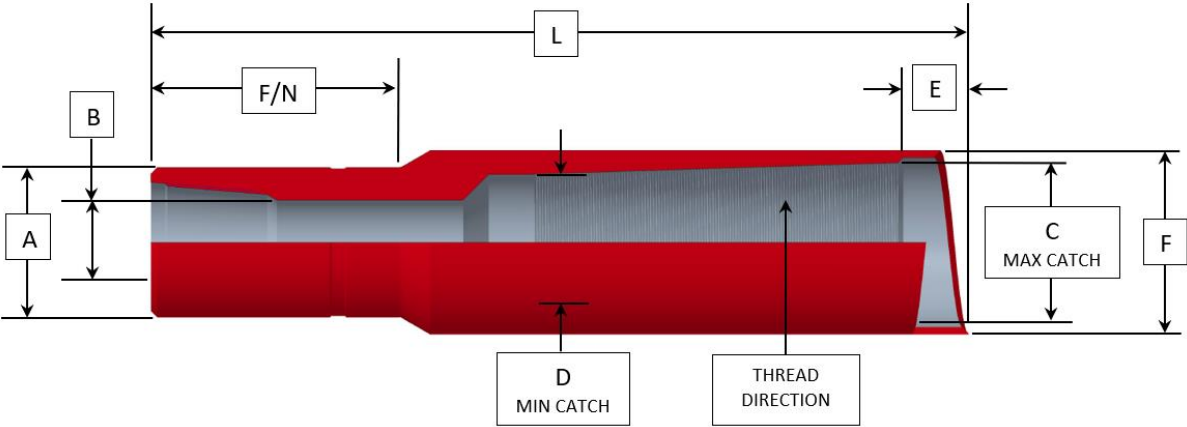


CASING DATA		Taper Mill PN:	Dimensional Parameters								
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F in.	F/N in.	L in.
4 1/2	9.5 to 13.5	112269	Nominal	3.13	1.00	3.34	2.25	1.14	3.75	8.00	27.00
			MIN	3.10	.97	3.31	2.22	1.11	3.72	7.00	26.00
			MAX	3.16	1.06	3.37	2.28	1.17	3.78	8.50	27.50
5.0	11.50 & 15	112320	Nominal	3.13	1.00	3.83	2.00	1.21	4.25	10.00	46.00
			MIN	3.10	.97	3.80	1.97	1.18	4.22	8.00	44.00
			MAX	3.16	1.06	3.86	2.03	1.24	4.28	10.50	46.50
5 1/2	14 to 17	112352	Nominal	3.38	1.75	4.38	3.50	1.57	3.69	10.00	48.00
			MIN	3.35	1.72	4.35	3.47	1.54	3.66	8.00	46.00
			MAX	3.41	1.81	4.41	3.53	1.60	3.72	10.50	48.50
		112343	Nominal	3.38	1.75	4.03	2.50	1.12	4.62	10.00	41.50
			MIN	3.35	1.72	4.00	2.47	1.09	4.59	8.00	39.50
			MAX	3.41	1.81	4.06	2.53	1.15	4.65	10.50	42.00
	20 to 23	112339	Nominal	3.38	1.75	4.25	2.50	1.12	4.50	10.00	37.50
			MIN	3.35	1.72	4.22	2.47	1.09	4.47	8.00	35.50
			MAX	3.41	1.81	4.28	2.53	1.15	4.53	10.50	38.00
6 5/8	17 to 20	112304	Nominal	4.75	2.68	5.38	4.38	1.66	5.94	12.00	50.00
			MIN	4.72	2.65	5.35	4.35	1.63	5.91	8.00	46.00
			MAX	4.78	2.74	5.41	4.41	1.69	5.97	12.50	50.50
	24 to 32	895940	Nominal	4.75	2.68	4.88	3.25	2.19	5.44	10.00	37.00
			MIN	4.72	2.65	4.85	3.22	2.16	5.41	8.00	35.00
			MAX	4.78	2.74	4.91	3.28	2.22	5.47	10.50	37.50

Note:

1. All Box Taps Wicker threads are Right hand direction

	39 of 44	Box tap/Die Collar Field Inspection Criteria				
DOCUMENT NUMBER	CLASSIFICATION	DOCUMENT LEVEL	REVISION	ISSUE DATE	PREPARED BY	APPROVAL
GL-INTS-OEPS-L4-459	CONTROLLED	Technical Manual	L	OCT 2024	Santosh Bhadran	Ron Barker

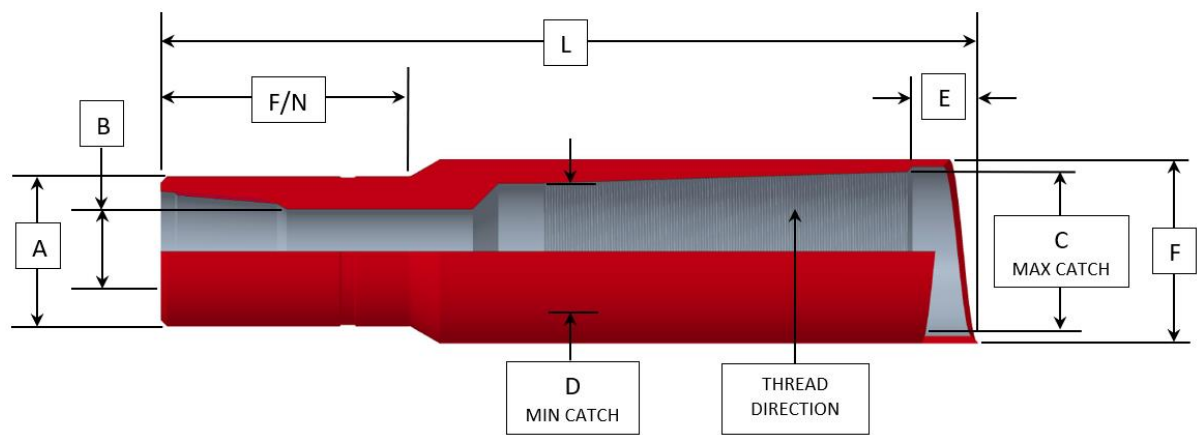


CASING DATA		Taper Mill PN:	Dimensional Parameters								
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F in.	F/N in.	L in.
7.0	17-20 & 29 SD	763112	Nominal	4.75	3.00	5.38	3.50	1.26	6.13	10.00	43.50
			MIN	4.72	2.97	5.35	3.47	1.23	6.10	8.00	41.50
			MAX	4.78	3.03	5.41	3.53	1.29	6.16	10.50	44.00
		109846	Nominal	4.75	2.68	5.38	4.38	1.81	6.00	12.00	50.00
			MIN	4.72	2.65	5.35	4.35	1.78	5.97	8.00	46.00
			MAX	4.78	2.74	5.41	4.41	1.84	6.03	12.50	50.50
	29 to 35	113065	Nominal	4.75	2.68	5.34	3.66	1.64	5.86	12.00	45.00
			MIN	4.72	2.65	5.31	3.63	1.61	5.83	8.00	41.00
			MAX	4.78	2.74	5.37	3.69	1.67	5.89	12.50	45.50
7 5/8	20 24 to 29.7	112748	Nominal	4.75	2.68	6.00	5.00	2.14	6.69	10.00	50.00
			MIN	4.72	2.65	5.97	4.97	2.11	6.66	8.00	48.00
			MAX	4.78	2.74	6.03	5.03	2.17	6.72	10.50	50.50
		112327	Nominal	4.75	2.68	6.00	4.00	2.14	6.50	10.00	50.00
			MIN	4.72	2.65	5.97	3.97	2.11	5.47	8.00	48.00
			MAX	4.78	2.74	6.03	4.03	2.17	6.53	10.50	50.50
	33.7 To 39	112588	Nominal	4.75	2.68	6.00	4.00	2.21	6.63	10.00	50.00
			MIN	4.72	2.65	5.97	3.97	2.18	5.60	8.00	48.00
			MAX	4.78	2.74	6.03	4.03	2.24	6.66	10.50	50.50
8 5/8	24 to 38	112437	Nominal	6.63	3.75	6.88	4.88	2.19	7.50	10.00	49.50
			MIN	6.60	3.72	6.85	4.85	2.16	7.47	8.00	47.50
			MAX	6.66	3.78	6.91	4.91	2.22	7.53	10.50	50.00

Note:

1. All Box Taps Wicker threads are Right hand direction

	40 of 44	Box tap/Die Collar Field Inspection Criteria				
DOCUMENT NUMBER	CLASSIFICATION	DOCUMENT LEVEL	REVISION	ISSUE DATE	PREPARED BY	APPROVAL
GL-INTS-OEPS-L4-459	CONTROLLED	Technical Manual	L	OCT 2024	Santosh Bhadran	Ron Barker

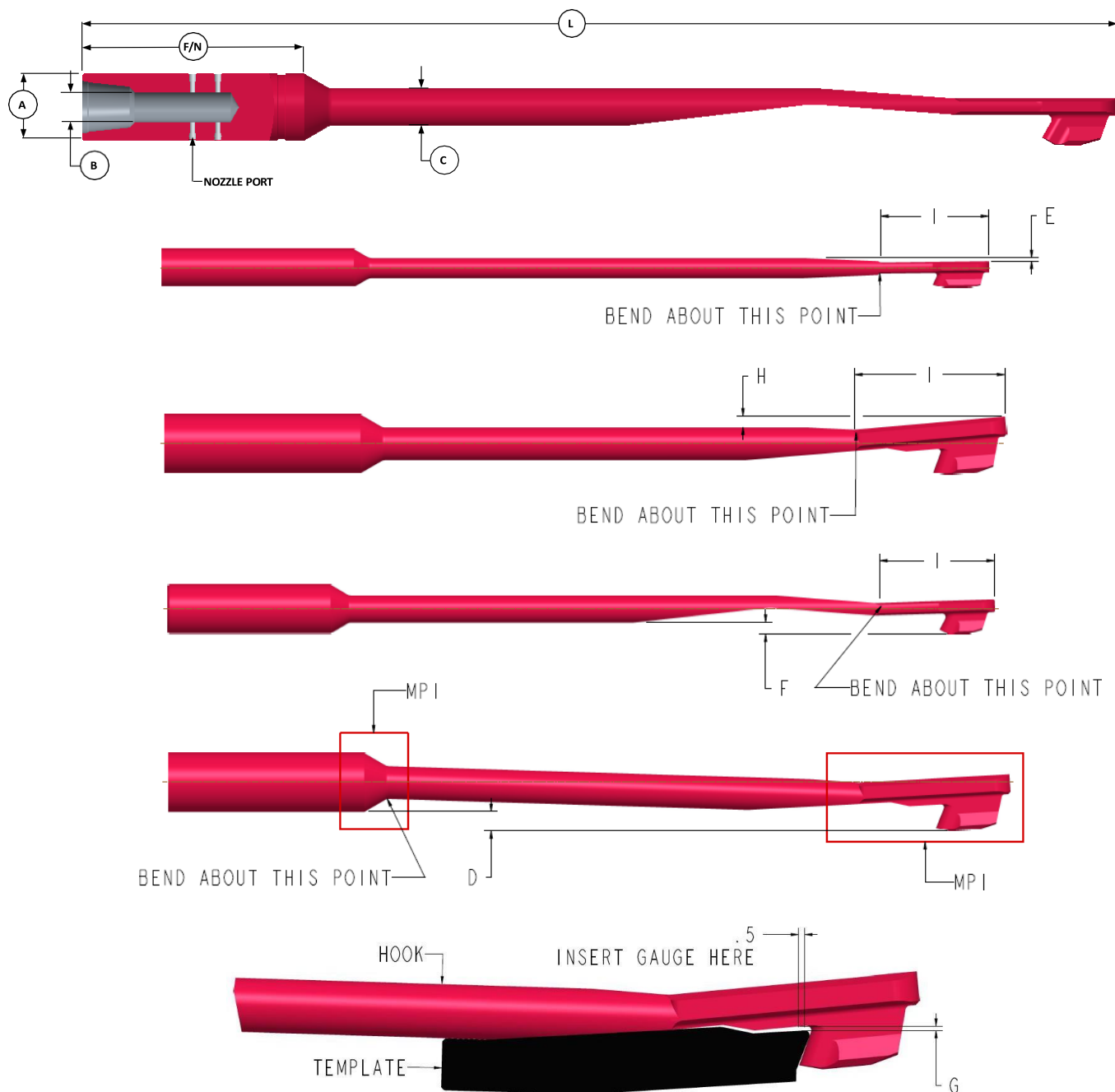


CASING DATA		Taper Mill PN:	Dimensional Parameters								
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F in.	F/N in.	L in.
9 5/8	32.3 to 40	718263	Nominal	6.63	3.75	7.75	5.50	2.19	8.63	10.00	39.00
			MIN	6.60	3.72	7.72	5.47	2.16	8.60	8.00	37.00
			MAX	6.66	3.81	7.78	5.53	2.22	8.66	10.50	39.50
		112536	Nominal	6.63	3.75	7.27	5.38	2.31	8.25	12.00	44.00
			MIN	6.60	3.72	7.24	5.35	2.28	8.22	8.00	40.00
			MAX	6.66	3.81	7.30	5.41	2.34	8.28	12.50	44.50
	43.5 to 58.4	110041	Nominal	6.13	2.25	7.75	5.13	2.20	8.35	12.00	48.00
			MIN	6.10	2.23	7.72	5.10	2.17	8.32	8.00	44.00
			MAX	6.16	2.31	7.78	5.16	2.23	8.38	12.50	48.50
10 3/4	32.7 to 55.5	112382	Nominal	7.75	3.50	8.75	6.08	2.45	9.56	10.00	52.00
			MIN	7.72	3.47	8.72	6.05	2.42	9.53	8.00	50.00
			MAX	7.78	3.56	8.78	6.11	2.48	9.59	10.50	52.50
11 3/4	38 to 60	113009	Nominal	7.75	3.50	9.75	7.75	2.25	10.50	10.00	52.00
			MIN	7.72	3.47	9.72	7.72	2.22	10.47	8.00	50.00
			MAX	7.78	3.56	9.78	7.78	2.28	10.53	10.50	53.00
	38 to 54	112765	Nominal	7.75	3.50	9.75	7.75	2.25	10.75	10.00	52.00
			MIN	7.72	3.47	9.72	7.72	2.22	10.72	8.00	50.00
			MAX	7.78	3.56	9.78	7.78	2.28	10.78	10.50	53.00
13 3/8	68 to 72	112355	Nominal	7.75	3.50	11.44	9.44	2.22	12.13	12.00	55.00
			MIN	7.72	3.47	11.41	9.41	2.19	12.10	8.00	51.00
			MAX	7.78	3.56	11.47	9.47	2.25	12.16	12.50	55.50
16	55 to 95	1190407	Nominal	9.00	4.00	13.00	11.63	2.50	14.50	18.30	70.00
			MIN	8.97	3.97	12.97	11.60	2.47	14.47	10.00	61.70
			MAX	9.03	4.06	13.03	11.66	2.53	14.53	18.80	70.50
18 5/8 20	78 to 187	775174	Nominal	9.00	4.00	15.46	14.00	3.50	17.38	18.30	75.00
			MIN	8.97	3.97	15.43	13.97	3.47	17.35	10.00	66.70
			MAX	9.03	4.06	15.49	14.03	3.53	17.41	18.80	75.50

Note:

1. All Box Taps Wicker threads are Right hand direction

	41 of 44	Retrieval Hook Field Inspection Criteria				
DOCUMENT NUMBER	CLASSIFICATION	DOCUMENT LEVEL	REVISION	ISSUE DATE	PREPARED BY	APPROVAL
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HOW TO MEASURE HOOK TEMPLATE GAP (G)

1. Select the appropriate feeler gauge(s)
2. Select the correct size of Retrieval Hook template to check profile on the hook as shown
3. From the start of the template radius, insert 0.5-in wide feeler gauge(s) into the gap
4. If the gauge(s) cannot be inserted into the gap, hook gap is below gauge(s) dimension
5. If the gauge(s) can be inserted into the gap, hook gap is gauge dimension and above

	42 of 44	Retrieval Hook Field Inspection Criteria					
DOCUMENT NUMBER		CLASSIFICATION	DOCUMENT LEVEL	REVISION	ISSUE DATE	PREPARED BY	APPROVAL
GL-INTS-OEPS-L4-459		CONTROLLED	Technical Manual	L	OCT 2024	Santosh Bhadran	Ron Barker

CASING DATA		Retrieval Hook PN:	Dimensional Parameters																				
OD in.	Weight lb./ft.			A in.	B in.	C in.	D in.	E in.	F in.	H in.	I in.	L in.	F/N in.	T/J Conn	Hook Type								
5 1/2	14-17	109848	NOM	3.75	1.00	2.00	1.74	0.33	N/A	N/A	(10.40)	81.9	15.5	2-7/8	QC								
5 3/4	17.6-21.5		MIN	3.72	0.97	1.97	1.71	0.30				81.4	15.0	REG									
			MAX	3.78	1.03	2.03	1.77	0.36				82.1	16.0	Pin*									
6 5/8	17-20	230358	NOM	4.75	1.12	2.64	2.58	0.25	N/A	N/A	(10.30)	89.5	18.6	3-1/2 IF Box	QC								
			MIN	4.72	1.09	2.61	2.55	0.22				89.0	18.1										
			MAX	4.78	1.15	2.67	2.61	0.28				89.7	19.1										
	24-32	913488	NOM	4.50	1.12	2.64	1.37	0.25	N/A	N/A	(10.40)	89.5	19.0	3-1/2 IF Box	QC								
			MIN	4.47	1.09	2.61	1.34	0.22				89.0	18.5										
			MAX	4.53	1.15	2.67	1.40	0.28				89.7	19.5										
7	29-38	230358	NOM	4.75	1.12	2.64	2.58	0.25	N/A	N/A	(10.30)	89.5	18.6	3-1/2 IF Box	QC/ SAQC								
	20-29SD		MIN	4.72	1.09	2.61	2.55	0.22				89.0	18.1		QC								
7 5/8	33.7-39											89.7	19.1										
	24-29.7		MAX	4.78	1.15	2.67	2.61	0.28															
8 5/8 9 5/8	24-38	231091	NOM	6.25	2.25	3.00	1.00	N/A	N/A	0.06	(13.50)	96.5	26.0	4-1/2 IF Box	QC								
			MIN	6.22	2.22	2.97	0.97			0.03		96.0	25.5										
			MAX	6.28	2.28	3.03	1.03			0.09		96.7	26.5										
9 5/8	32-58.4	290904	NOM	6.25	2.25	3.00	2.06	0.60	N/A	N/A	(13.50)	140.5	26.0	4-1/2 IF Box	SAQC								
			MIN	6.22	2.22	2.97	2.03	0.57				140.0	25.5										
			MAX	6.28	2.28	3.03	2.09	0.63				140.7	26.5										
10 3/4	32.75-65	807614	NOM	7.75	3.50	4.31	2.73	N/A	1.50	N/A	(18.80)	133.2	26.2	6-5/8 REG Box	QC/ SAQC								
11 3/4	38-60		MIN	7.72	3.47	4.28	2.70		1.47			132.7	25.7										
			MAX	7.78	3.53	4.34	2.76		1.53			133.4	26.7										
13 3/8	48-72	724072	NOM	7.75	3.50	4.31	2.54	N/A	N/A	1.40	(19.90)	111.3	26.2	6-5/8 REG Box	QC/SAQC								
16	55-84									QC													
18 5/8	78-94.5											1.37	110.8		25.7								
												1.43	111.5		26.7								
20	90-187	MAX	7.78	3.53	4.34	2.57																	

HOOK TEMPLATE GAP (G) ACCEPTANCE CRITERIA														
Retrieval Hook PN	109848		230358		913488		231091		290904		807614		724072	
	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX
Acceptable for use		0.046		0.046		0.046		0.077		0.046		0.062		0.077
Re-bend	*0.047	0.249	*0.047	0.249	*0.047	0.249	*0.078	0.499	*0.047	0.249	*0.063	0.312	*0.078	0.499
Scrap	*0.250		*0.250		*0.250		*0.500		*0.250		*0.313		*0.500	

*Gauge(s) sizes to use

Center punch around hook stamp location each time hook is re-bent. Maximum number of re-bent is 2 times. Hook that is out of usable tolerance after re-bending 2 times should be scrapped.

- NOTES:**
- Inspect Tool Joint nozzle ports for overall condition including erosion or any other damage.
 - MPI the tool joint/mandrel transition including all bends as above for any cracking.
 - Tool joint connections should inspect as per DS1 VOL 3 latest edition CAT3-5.
 - Overall body visual check for any damages.
 - *Overall length & Fish Neck length given that excluded the pin length. (Ref PN: 109848)

	43 of 44	Retrieval Hook Field Inspection Criteria				
DOCUMENT NUMBER	CLASSIFICATION	DOCUMENT LEVEL	REVISION	ISSUE DATE	PREPARED BY	APPROVAL
GL-INTS-OEPS-L4-459	CONTROLLED	Technical Manual	L	OCT 2024	Santosh Bhadran	Ron Barker

HOOK INSPECTION MEASUREMENT TEMPLATES

Casing	Casing Weight	Whipstock OD	Hook Assembly P/N	Whipstock Type	Box Connection	Template
5 1/2	14-17	4.5	109848	QC	2-7/8 API REG	2601696
5 3/4	17.6-21.5	4.5				
6 5/8	17-20	5.5	230358	QC	3-1/2 API IF	2601697
	24-32	5.25	913488			2601698
7	29-38	5.5	230358	QC/SAQC	3-1/2 API IF	2601697
	20-29SD	5.5		QC		
7 5/8	33.7-39	6				
	24-29.7	6.25				
8 5/8	24-38	7	231091	QC	4-1/2 API IF	2601699
9 5/8	32-58.4	8		290904		SAQC
10 3/4	32.75-65	9	807614	QC/SAQC	6-5/8 API REG	2601701
11 3/4	38-60	10		QC/SAQC		2601702
13 3/8	48-72	11.5	724072			
16	55-84	14				
18 5/8	78-94.5	17				
20	90-187					

Document Change Record

Rev	Date	Page	Revised By	Part Affected	Change Description
H	Jan 2023	10	R Barker	12-1/4-in Lead Mill 48-72SD	Blade OD tolerance is .015-in
I	April 2024	30	R Barker	Flex Mandrel	Header Description
J	June 2024	30-35	Barker/Bhadran	Mandrel/Mills	Added Mandrel, Conventional Mills
K	June 2024	31-35	Barker/Bhadran	CONV Mills	Matched with MIR details
L	OCT 2024	38-40	Barker/Bhadran	Box Tap	Insp criteria added, new addition
		41-43		Retrieval Hook	Insp criteria added, new addition
		34		8.62 Window mill	Insp criteria added, new addition
		1-44		Document header changed to have OEPS version	